

Grizzly *Industrial, Inc.*®

MODEL G0717 9" x 16" METAL CUTTING BANDSAW OWNER'S MANUAL



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
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(FOR MODELS MANUFACTURED SINCE 9/10) #JB14154 PRINTED IN TAIWAN



WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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INTRODUCTION

Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes we still make an occasional mistake.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your machine by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your machine.

		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		WARNING!	
Motor:		Manufacture Date of Your Machine When using this machine: 1. Always wear safety glasses and respirator. 2. Read and understand the manual before starting. 3. Do not touch the blade or workpiece while the machine is running. 4. Make sure the motor has stopped and disconnect power before adjustments, maintenance, or service. 5. DO NOT expose to rain or dampness. 6. DO NOT modify this machine in any way. 7. DO NOT remove safety guards. 8. Never leave machine running unattended. 9. DO NOT operate under the influence of drugs or alcohol. 10. Maintain machine carefully to prevent accidents.	
Specification:			
Specification:			
Specification:			
Weight:			
<input type="text"/>	Date		
<input type="text"/>	Serial Number		
Manufactured for Grizzly in Taiwan			

For your convenience, we post all available manuals and manual updates for free on our website at www.grizzly.com. Any updates to your model of machine will be reflected in these documents as soon as they are complete.

Contact Info

We stand behind our machines. If you have any questions or need help, use the information below to contact us. Before contacting, please get the serial number and manufacture date of your machine. This will help us help you faster.

Grizzly Technical Support
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Email: techsupport@grizzly.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

Machine Description

The Model G0717 metal cutting bandsaw makes straight cuts in metal workpieces. An integrated cutting fluid system cools the blade and workpiece for more efficient operations. Hydraulically controlled downfeed allows for hands-free cuts.



Identification



Figure 3. Identification.

- | | |
|-----------------------------------|----------------------------------|
| A. Blade Tension Handwheel | J. Work Stop |
| B. Saw Lift Handle | K. Leveling Foot |
| C. Upper Wheel Cover | L. Vise Handwheel |
| D. Saw Bow | M. Vise Quick Adjustment |
| E. Control Panel | N. Blade Guard |
| F. Lower Wheel Cover | O. Blade |
| G. Motor | P. Vise |
| H. Work Stop Rod | Q. Blade Guide Assemblies |
| I. Chip Tray | |





MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL G0717 9" X 16" METAL CUTTING BANDSAW

Product Dimensions:

Weight..... 577 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 63-1/2 x 27 x 41 in.
Footprint (Length x Width)..... 16 x 38 in.

Shipping Dimensions:

Type..... Wood Slat Crate
Content..... Machine
Weight..... 673 lbs.
Length x Width x Height..... 69 x 30 x 48 in.

Electrical:

Power Requirement..... 110V or 220V, Single-Phase, 60Hz
Prewired Voltage..... 220V
Minimum Circuit Size..... 20A at 110V, 15A at 220V
Switch..... Push Button ON/OFF
Switch Voltage..... 220V
Cord Length..... 7 ft.
Cord Gauge..... 14 Gauge
Plug Included..... No
Recommended Plug/Outlet Type..... NEMA 5-20 for 110V, or 6-15 for 220V

Motors:

Main

Type..... TEFC Capacitor Start Induction
Horsepower..... 1-1/2 HP
Voltage..... 110V/220V
Prewired..... 220V
Phase..... Single-Phase
Amps..... 14A at 110V, 7A at 220V
Speed..... 1725 RPM
Cycle..... 60 Hz
Power Transfer V-Belt + Gear
Bearings..... 6205ZZ, Shielded & Lubricated

Main Specifications:

Operation Info

Blade Speeds..... 83, 132, 170, 235 FPM
Std. Blade Length..... 119-1/2 in.



Cutting Capacities

Angle Cuts.....	45-90 deg.
Vise Jaw Depth.....	13-1/4 & 8 in.
Vise Jaw Height.....	4-15/16 in.
Max. Capacity Rectangular Height at 90 Deg.....	15-3/4 in.
Max. Capacity Rectangular Width at 90 Deg.....	8-7/8 in.
Max. Capacity Round at 90 Deg.....	8-7/8 in.
Max. Capacity Rectangular Height at 30 Deg.....	8-7/16 in.
Max. Capacity Rectangular Width at 30 Deg.....	9-13/16 in.
Max. Capacity Round at 30 Deg.....	8-7/16 in.
Max. Capacity Rectangular Height at 45 Deg.....	8-7/8 in.
Max. Capacity Rectangular Width at 45 Deg.....	6-1/2 in.
Max. Capacity Round at 45 Deg.....	6-1/2 in.

Construction

Table.....	Precision-Ground Cast Iron
Upper Wheel.....	Cast Iron
Lower Wheel.....	Cast Iron
Body.....	Steel
Base.....	Pre-Formed Steel
Stand.....	Pre-Formed Steel
Wheel Cover.....	Cast Iron
Paint.....	Powder Coated

Other

Wheel Size.....	13 in.
Blade Guides Upper.....	Ball Bearing
Blade Guides Lower.....	Ball Bearing
Coolant Cap.....	5-1/2 gal.

Table Info

Table Size Length.....	16-7/8 in.
Table Size Width.....	11-3/8 in.
Floor To Cutting Area Height.....	25 in.

Other Specifications:

ISO Factory	ISO 9001
Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	ID Label on Front of Machine
Assembly Time	60 Minutes
Sound Rating	80 dB

Features:

- Front side access for blade changes
- Blade tension indicator
- Flood coolant pump with 2 nozzles
- Heavy-duty auto-stop switch
- Centralized controls
- Hydraulic feed rate controls
- Quick set vise
- Ball bearing blade guides




SECTION 1: SAFETY

WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

 **DANGER** Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.

 **WARNING** Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.

 **CAUTION** Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

NOTICE This symbol is used to alert the user to useful information about proper operation of the machine.

WARNING

Safety Instructions for Machinery

OWNER'S MANUAL. Read and understand this owner's manual **BEFORE** using machine. Untrained users can be seriously hurt.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are not approved safety glasses.

HAZARDOUS DUST. Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and always wear a NIOSH-approved respirator to reduce your risk.

WEARING PROPER APPAREL. Do not wear clothing, apparel, or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips which could cause a loss of workpiece control.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

MENTAL ALERTNESS. Be mentally alert when running machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.



WARNING

DISCONNECTING POWER SUPPLY. Always disconnect machine from power supply before servicing, adjusting, or changing cutting tools (bits, blades, cutters, etc.). Make sure switch is in OFF position before reconnecting to avoid an unexpected or unintentional start.

APPROVED OPERATION. Untrained operators can be seriously hurt by machinery. Only allow trained or properly supervised people to use machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in wet or rainy locations, cluttered areas, around flammables, or in poorly-lit areas. Keep work area clean, dry, and well-lighted to minimize risk of injury.

ONLY USE AS INTENDED. Only use machine for its intended purpose. Never modify or alter machine for a purpose not intended by the manufacturer or serious injury may result!

USE RECOMMENDED ACCESSORIES. Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

CHILDREN & BYSTANDERS. Keep children and bystanders a safe distance away from work area. Stop using machine if children or bystanders become a distraction.

REMOVE ADJUSTING TOOLS. Never leave adjustment tools, chuck keys, wrenches, etc. in or on machine—especially near moving parts. Verify removal before starting!

SECURING WORKPIECE. When required, use clamps or vises to secure workpiece. A secured workpiece protects hands and frees both of them to operate the machine.

FEED DIRECTION. Unless otherwise noted, feed work against the rotation of blades or cutters. Feeding in the same direction of rotation may pull your hand into the cut.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

GUARDS & COVERS. Guards and covers can protect you from accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly before using machine.

NEVER STAND ON MACHINE. Serious injury or accidental contact with cutting tool may occur if machine is tipped. Machine may be damaged.

STABLE MACHINE. Unexpected movement during operations greatly increases the risk of injury and loss of control. Verify machines are stable/secure and mobile bases (if used) are locked before starting.

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

UNATTENDED OPERATION. Never leave machine running while unattended. Turn machine **OFF** and ensure all moving parts completely stop before walking away.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. An improperly maintained machine may increase the risk of serious injury.

CHECK DAMAGED PARTS. Regularly inspect machine for damaged parts, loose bolts, mis-adjusted or mis-aligned parts, binding, or any other conditions that may affect safe operation. Always repair or replace damaged or mis-adjusted parts before operating machine.

EXPERIENCING DIFFICULTIES. If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Technical Support Department at (570) 546-9663.



WARNING

Safety Instructions for Metal Cutting Bandsaws

BLADE CONDITION. Do not operate with dull, cracked or badly worn blade. Inspect blades for cracks and missing teeth before each use.

HAND PLACEMENT. Never position fingers or thumbs in line with the cut. Hands could be crushed in vise or from falling machine components.

ENTANGLEMENT HAZARDS. Do not operate this bandsaw without blade guard in place. Loose clothing, jewelry, long hair and work gloves can be drawn into working parts.

BLADE REPLACEMENT. When replacing blades, make sure teeth face toward the workpiece. Wear gloves to protect hands and safety glasses to protect eyes.

WORKPIECE HANDLING. Always support the workpiece with table, vice, or some type of support fixture. Flag long pieces to avoid a tripping hazard. Never hold the workpiece with your hands during a cut.

LOSS OF STABILITY. Unsupported workpieces may jeopardize machine stability and cause the machine to tip and fall which could cause serious injury.

POWER INTERRUPTION. Unplug machine after power interruption. Machines without magnetic switches can start up after power is restored.

FIRE HAZARD. Use EXTREME CAUTION if cutting magnesium. Using the wrong cutting fluid will lead to chip fire and possible explosion.

CUTTING FLUID SAFETY. Always follow manufacturer's cutting-fluid safety instructions. Pay particular attention to contact, contamination, inhalation, storage and disposal warnings. Spilled cutting fluid invites slipping hazards.

ATTENTION TO WORK AREA. Never leave a machine running and unattended. Pay attention to the actions of others in the area to avoid unintended accidents.

MAINTENANCE/SERVICE. All inspections, adjustments, and maintenance are to be done with the machine disconnected from the power supply.

HEARING PROTECTION & HAZARDS. Noise generated by blade and workpiece vibration, material handling, and power transmission can cause permanent hearing loss over time and interfere with communication and audible signals.

HOT SURFACES. Contact with hot surfaces from machine components, ejections of hot chips, swarf and workpiece can cause burns.

WARNING

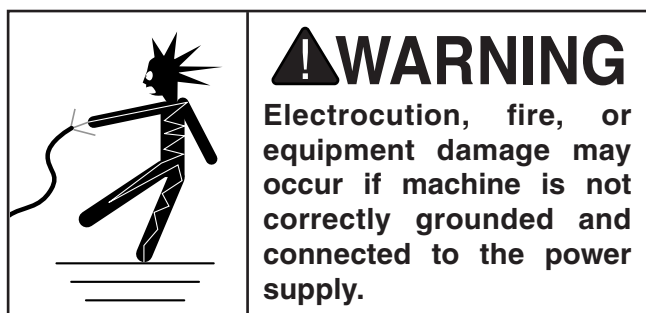
No list of safety guidelines can be complete. Every shop environment is different. Like all machines there is danger associated with the Model G0717. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.



SECTION 2: POWER SUPPLY

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by a qualified electrician in accordance with all applicable codes and standards.



Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating at 220V 7 Amps

Full-Load Current Rating at 110V 14 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the requirements in the following section.

Circuit Information

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

! CAUTION
For your own safety and protection of property, consult a qualified electrician if you are unsure about wiring practices or electrical codes in your area.

Note: *The circuit requirements listed in this manual apply to a dedicated circuit—where only one machine will be running at a time. If this machine will be connected to a shared circuit where multiple machines will be running at the same time, consult a qualified electrician to ensure that the circuit is properly sized for safe operation.*

Circuit Requirements for 220V

This machine is prewired to operate on a 220V power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 220V/240V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 15 Amps
Plug/Receptacle NEMA 6-15

Circuit Requirements for 110V

This machine can be converted to operate on a 110V power supply (refer to **Voltage Conversion** instructions) that has a verified ground and meets the following requirements:

Nominal Voltage 110V/120V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 20 Amps
Plug/Receptacle NEMA 5-20



Grounding Requirements

This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

For 220V operation: This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (see following figure). The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances.

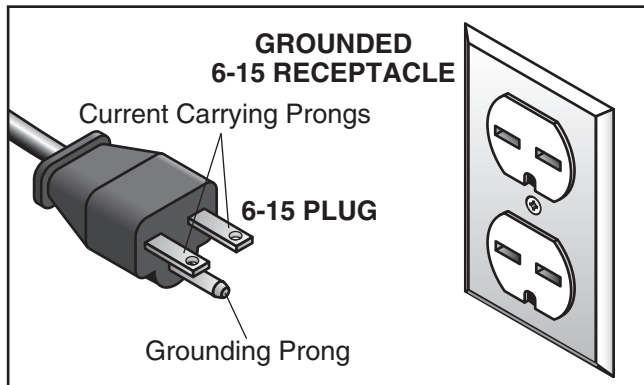


Figure 4. Typical 6-15 plug and receptacle.

⚠ CAUTION

No adapter should be used with the provided plug. If the plug does not fit the available receptacle, or the machine must be reconnected for use on a different type of circuit, the reconnection must be made by a qualified electrician and comply with all local codes and ordinances.

For 110V operation: The plug specified under “Circuit Requirements for 110V” on the previous page has a grounding prong that must be attached to the equipment-grounding wire inside the included power cord. The plug must only be inserted into a matching receptacle (see below) that is properly installed and grounded in accordance with all local codes and ordinances.

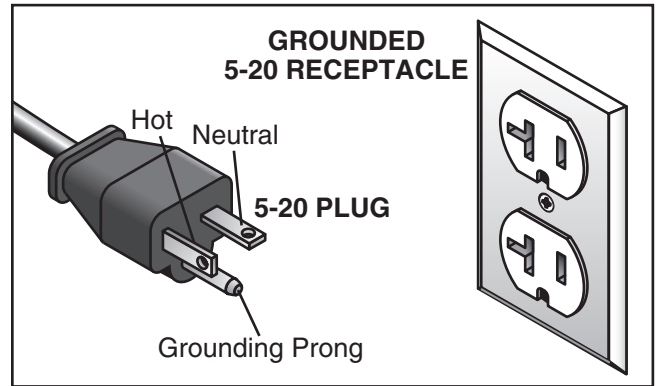


Figure 5. Typical 5-20 plug and receptacle.

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

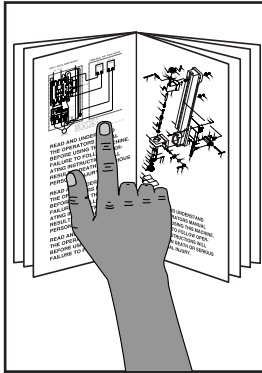
Extension cords cause voltage drop, which may damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must contain a ground wire, match the required plug and receptacle, and meet the following requirements:

- Minimum Gauge Size12 AWG**
- Maximum Length (Shorter is Better).....50 ft.**



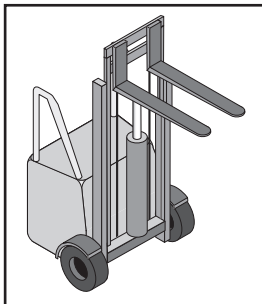
SECTION 3: SETUP



!WARNING
This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



!WARNING
Wear safety glasses during the entire setup process!



!WARNING
This machine and its components are very heavy. Use power lifting equipment such as a fork lift or hoist to move heavy items.

Needed for Setup

The following are needed to complete the setup process, but are not included with your machine.

Description	Qty
• Safety Glasses	1
• Cleaner/Degreaser	As Needed
• Disposable Shop Rags.....	As Needed
• Forklift.....	1
• Additional People	1
• Wrenches or Sockets 10, 13mm	1 Ea.

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover any damage, *please call us immediately at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.



!WARNING
SUFFOCATION HAZARD!
Keep children and pets away from plastic bags or packing materials unpacked with this machine. Discard immediately.



Inventory

The following is a description of the main components shipped with your machine. Lay the components out to inventory them.

If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

Item (Figure 6)	Qty
A. Bandsaw Unit (Not Shown)	1
B. Motor Assembly.....	1
C. Belt Cover.....	1
D. Work Stop Rod.....	1
E. Work Stop.....	1
F. Tool Box (Not Shown).....	1
• Phillips Screwdriver #2	1
• Flat Blade Screwdriver #2.....	1
• Hex Wrenches 3, 4, 5, 6mm	1 Ea.
• Combo Wrenches 11/13, 17/19	1 Ea.
• Hex Bolts M12-1.75 x 65	4
• Hex Nuts M12-1.75.....	4

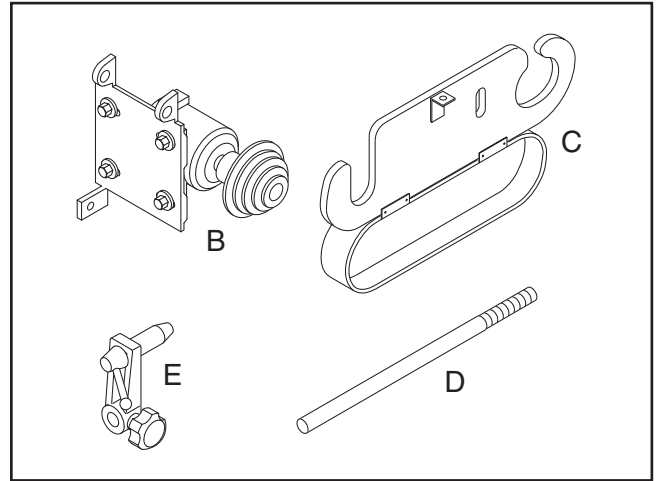


Figure 6. Inventory.

NOTICE

If you cannot find an item on this list, check the mounting location on the machine or the packaging materials. Sometimes parts are pre-installed for shipping, or they become hidden by packaging materials.



Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

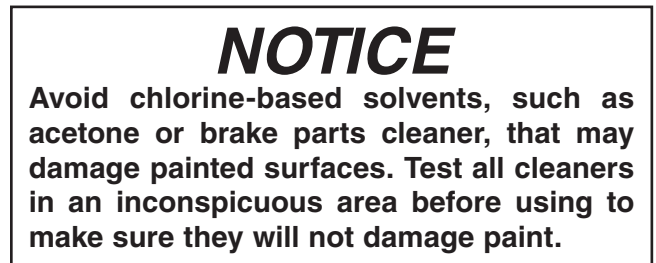
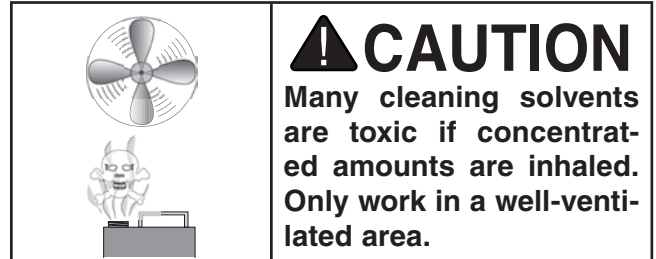
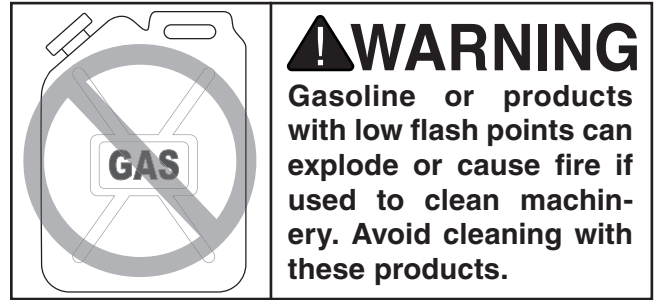
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

- Disposable Rags
- Cleaner/degreaser (WD•40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.



Site Considerations

Weight Load

Refer to the **Machine Data Sheet** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual. **See below for required space allocation.**



Physical Environment

The physical environment where your machine is operated is important for safe operation and the longevity of its components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave access to a means of disconnecting the power source or engaging a lockout/tagout device.

Lighting

Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

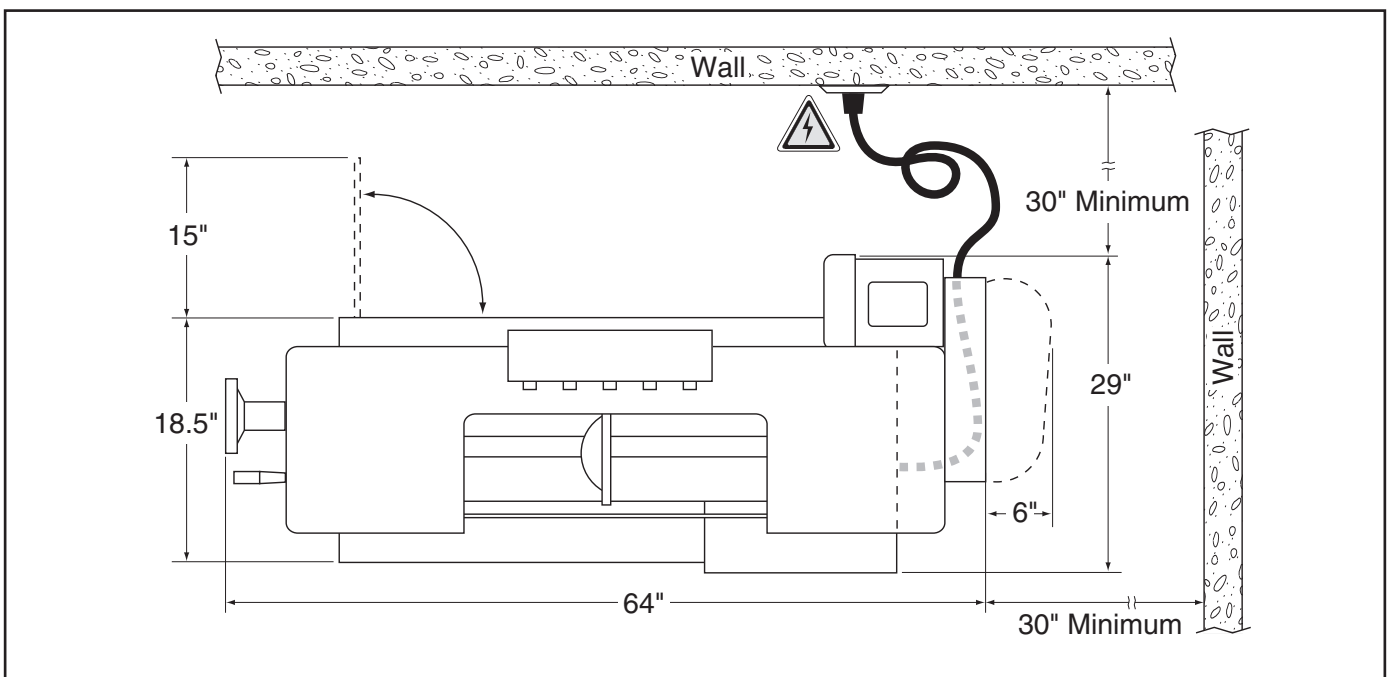
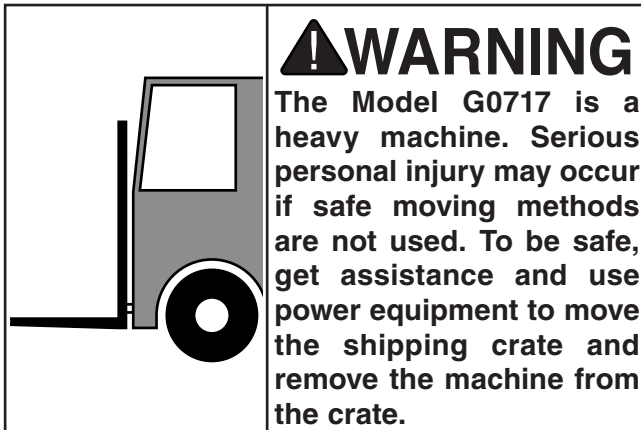


Figure 7. Minimum working clearances.



Lifting & Placing



Use a forklift rated for the machine weight to lift the machine off the pallet and onto a suitable location.

Mounting

Although not required, we recommend that you mount your new machine to the floor. Because this is an optional step and floor materials may vary, floor mounting hardware is not included. Generally, you can either bolt your machine to the floor or mount it on machine mounts. Both options are described below. Whichever option you choose, we recommend leveling your machine with a precision level.

Bolting to Concrete Floors

Lag shield anchors with lag screw (**Figure 8**) and anchor studs (**Figure 8**) are two popular methods for anchoring an object to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

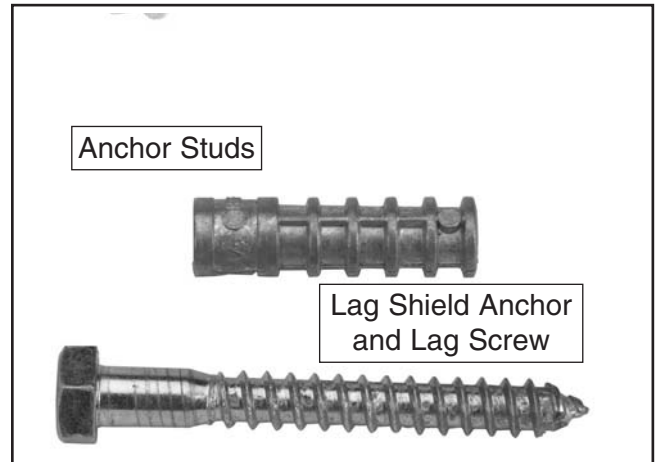


Figure 8. Typical fasteners for mounting to concrete floors.

NOTICE

Anchor studs are stronger and more permanent alternatives to lag shield anchors; however, they will stick out of the floor, which may cause a tripping hazard if you decide to move your machine.

Using Machine Mounts

Using machine mounts, shown in **Figure 9**, gives the advantage of fast leveling and vibration reduction. The large size of the foot pads distributes the weight of the machine to reduce strain on the floor.



Figure 9. Machine mount example.

NOTICE

We strongly recommend securing your machine to the floor if it is hardwired to the power source. Consult with your electrician to ensure compliance with local codes.



Assembly

Assembling the G0717 requires connection of the control panel to the top of the saw bow and installation of the motor and pulley cover.

To assemble your machine:

1. Remove the two hex bolts and washers shown in **Figure 10** from the top of the saw bow.

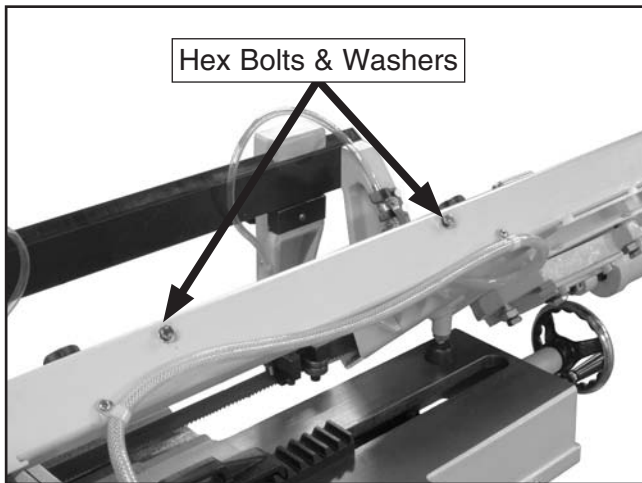


Figure 10. Remove hex bolts.

2. Remove any remaining packing material from around the control panel, then place it in position on top of the saw bow, being careful not to twist the cords/hoses.
3. Secure the control panel as shown in **Figure 11**, using the hardware removed in **Step 1**.

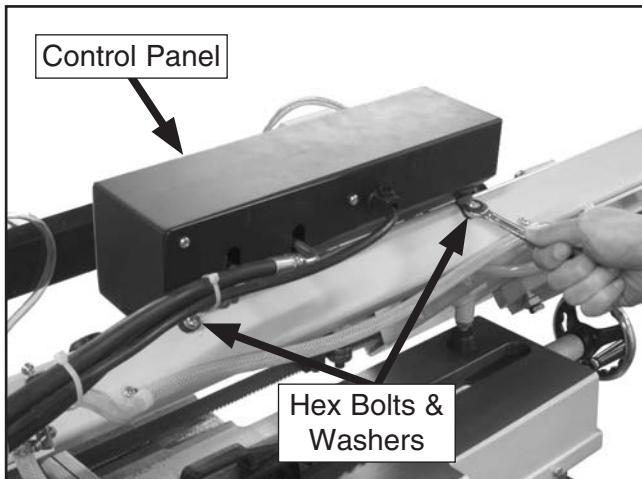


Figure 11. Attaching control panel.

4. Remove the motor pivot pin from the saw bow (See **Figure 12** for location).

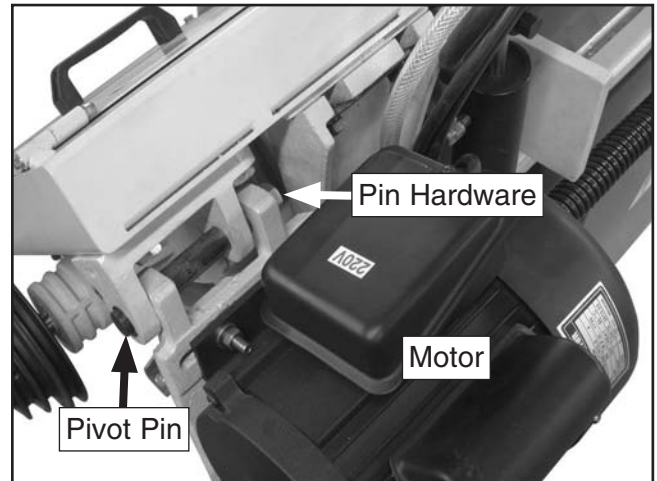


Figure 12. Mounting motor.

5. With the help of one or more assistants, lift the motor into position and re-insert the motor pivot pin.
6. Secure the motor pivot pin with the hardware removed in **Step 4** (See **Figure 12**).
7. Place the belt over the pulleys.
8. Remove the hex bolt shown in **Figure 13**.

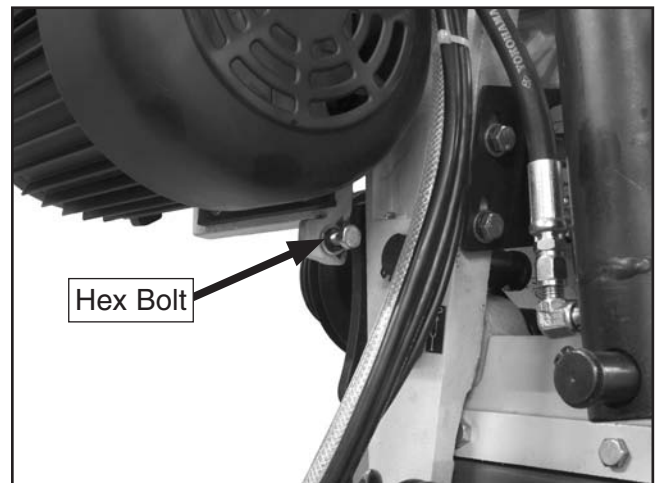


Figure 13. Motor adjustment bolt.

9. Rotate the motor tilt plate upward until it aligns with the hole from which the hex bolt was removed in **Step 8**, then re-install the hex bolt.
10. Tension the belt according to **Step 5** in **V-Belt** on **Page 43**.



11. Open the motor junction box, loosen the terminal screws indicated in **Figure 14**, feed the cord through the strain relief on the junction box, then connect the wires as shown.

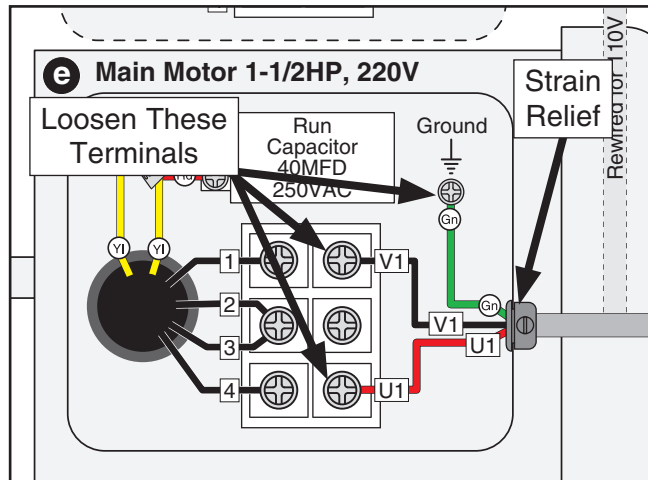


Figure 14. Wiring motor.

12. Make sure all wiring connections are secure, tighten the strain relief on the motor junction box to prevent the cord from being accidentally pulled out, then replace the motor junction box cover.
13. Remove the two hex bolts shown in **Figure 15**.



Figure 15. Belt cover hardware.

14. Slide the pulley cover behind the motor pulley first, then the gearbox pulley. Mount it using the hardware removed in **Step 13**, as shown in **Figure 16**.

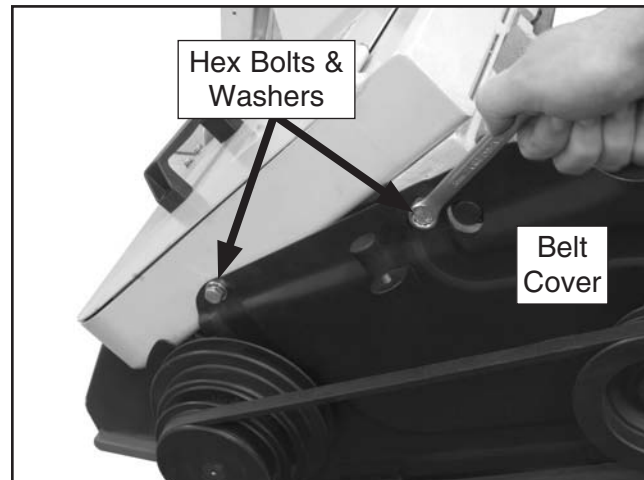


Figure 16. Mounting belt cover.



Power Connection

After you have completed all previous setup instructions and circuit requirements, the machine is ready to be connected to the power supply.

To avoid unexpected startups or property damage, use the following steps whenever connecting or disconnecting the machine.

NOTICE

The Model G0717 is prewired for 220V. If you plan to operate the machine at 110V, the motors must be rewired (see Page 46) and a 110V plug must be installed.

Connecting Power

1. Turn the machine power switch **OFF**.
2. Insert the power cord plug into a matching power supply receptacle. The machine is now connected to the power source.

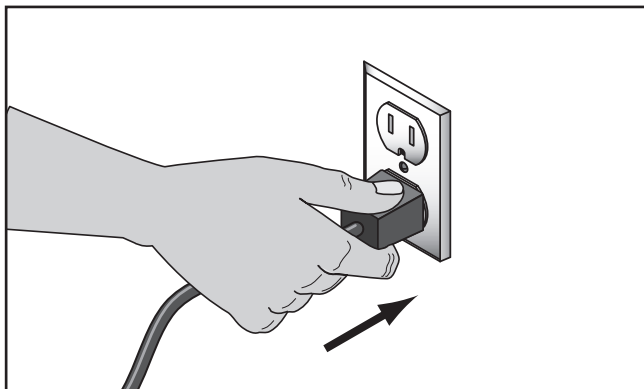


Figure 17. Connecting power.

Disconnecting Power

1. Turn the machine power switch **OFF**.
2. Grasp the molded plug and pull it completely out of the receptacle. Do not pull by the cord as this may damage the wires inside.

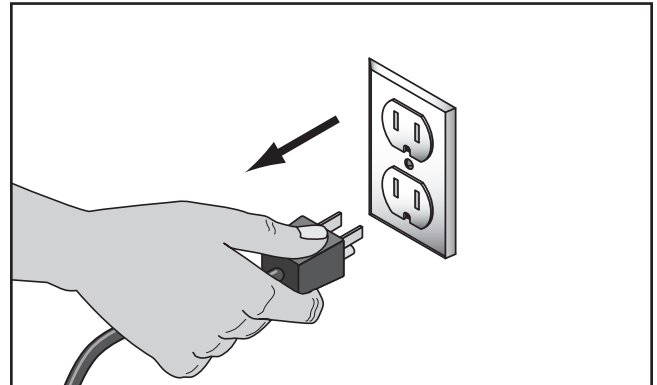


Figure 18. Disconnecting power.



Controls



Figure 19. Machine controls.

- A. Blade Tension Handwheel:** Controls blade tension. Turn clockwise to tighten blade and counterclockwise to loosen blade.
- B. Saw Lift Handle:** Used to raise and lower the saw bow.
- C. Blade Guide Adjust Knob:** Loosen to release and re-position the blade guide. Tighten to lock the blade guide in position.
- D. Work Stop:** Provides a positive stop at a given position. Best used during repetitive operations when multiple pieces must be cut at the same length.
- E. Vise Quick Adjustment:** Lift the handle and slide the jaw for rapid coarse adjustments.
- F. Vise Handwheel:** Opens and closes the vise jaw to clamp workpieces.



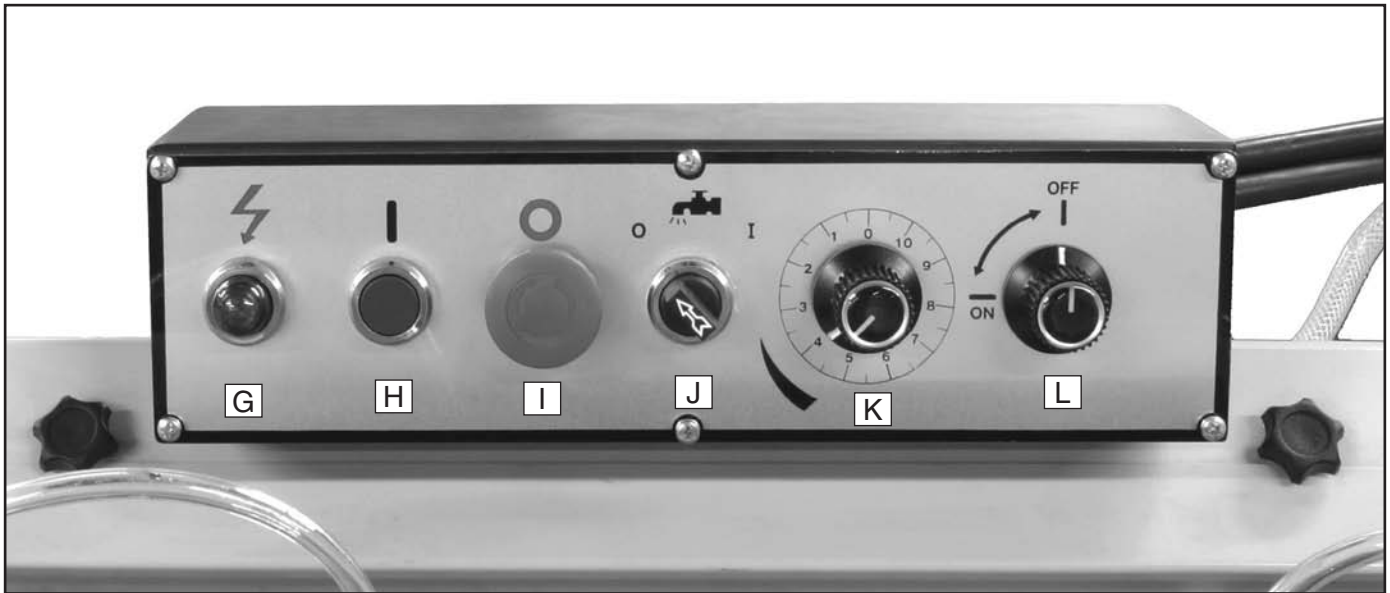


Figure 20. Control panel close-up.

- G. Power Indicator Lamp:** Lights when the machine is connected to power.
- H. Blade ON Button:** Starts the blade.
- I. Stop Button:** Stops the blade.
- J. Cutting Fluid Pump ON/OFF Switch:** Turns the cutting fluid pump **ON** and **OFF**.
- K. Downfeed Rate Control Knob:** Controls the downfeed rate with an adjustable hydraulic flow valve.
- L. Downfeed Start/Stop Knob:** Stops and starts downfeed at the established downfeed rate with a hydraulic shut-off valve.



Test Run

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation. The test run consists of verifying the following: 1) The motor powers up and runs correctly and 2) the stop button safety feature works correctly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review **Troubleshooting on Page 41**.

If you cannot find a remedy, contact our Tech Support at (570) 546-9663 for assistance.

WARNING

Before starting the saw, make sure you have performed the preceding assembly and adjustment instructions, and you have read through the rest of the manual and are familiar with the various functions and safety features on this machine. Failure to follow this warning could result in serious personal injury or even death!

To test run the machine:

1. Make sure you understand the safety instructions at the beginning of the manual and that the machine is setup properly.
2. Make sure all tools and objects used during setup are cleared away from the machine.
3. Add coolant to the cutting fluid reservoir (refer to **Cutting Fluid System on Page 34**).
4. Connect the machine to the power source.
5. Push the OFF button in, then twist it clockwise so it pops out. When the OFF button pops out, the switch is reset and ready for operation (see **Figure 21**).



Figure 21. Resetting the switch.

6. Raise the saw bow slightly, then verify that the machine is operating correctly by pushing the ON button.
 - When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.
 - Investigate and correct strange or unusual noises or vibrations before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.
7. Open the cutting fluid valve, then turn the cutting fluid pump switch to the ON position and verify that fluid pumps from the nozzle.
8. Press the OFF button to stop the machine.
9. WITHOUT resetting the switch, press the ON button. The machine should not start.
 - If the machine does not start, the OFF button safety feature is working correctly. The Test Run is complete.
 - If the machine does start (with the stop button pushed in), immediately disconnect power to the machine. The OFF button safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

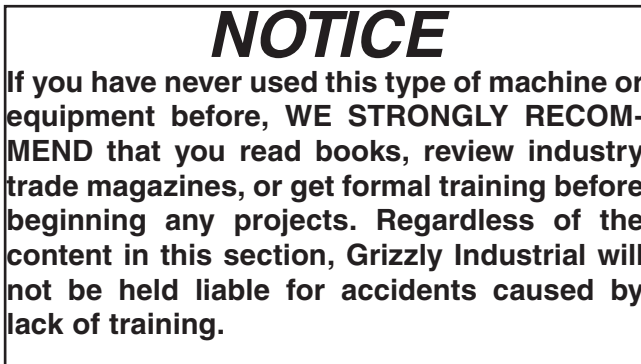
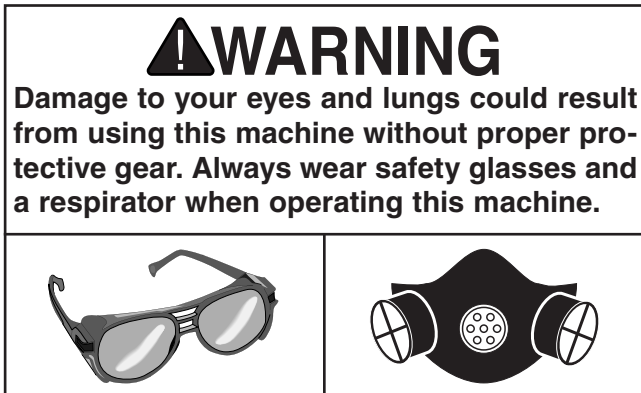


SECTION 4: OPERATIONS

Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual and seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.



To complete a typical cutting operation, the operator does the following:

1. Examines the workpiece to make sure it is suitable for cutting.
2. Raises the headstock, then closes the downfeed valve.
3. Adjusts the headstock angle for the type of cut, then securely clamps the workpiece in the vise.
4. Adjusts the guides as close as possible to the workpiece without contacting it, and verifies that the blade is properly tensioned.
5. Adjusts the downfeed rate adjust knob for the correct feed rate.
6. Makes sure the workpiece and bandsaw are stable and that there are no obstructions in the way of the cut.
7. Puts on safety glasses.
8. Starts the bandsaw and waits for the blade to reach full speed.
9. Opens the downfeed valve to lower the head and blade into the workpiece, then allows the bandsaw to complete the cut.
10. Once the bandsaw has stopped, raises the head, and removes the workpieces.



Blade Selection

Selecting the right blade for the cut requires a knowledge of various blade characteristics. This section breaks down blade characteristics to help the reader make an informed decision about what blade to use for a given operation.

Blade Terminology

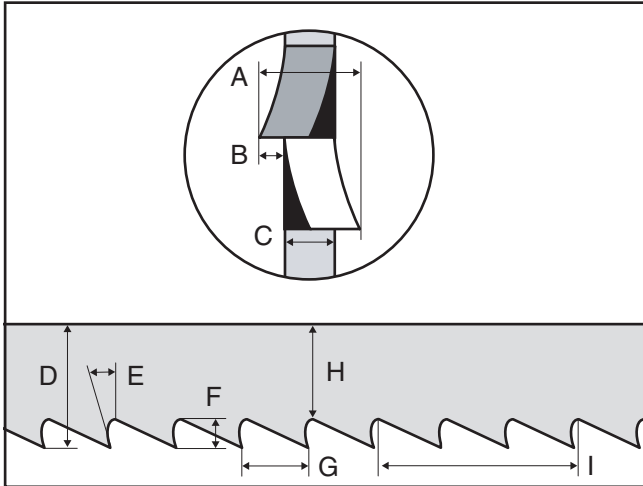


Figure 22. Bandsaw blade terminology.

- A. **Kerf:** The width of the cut made during operation.
- B. **Tooth Set:** The distance each tooth is bent left or right from the blade.
- C. **Gauge:** The thickness of the blade.
- D. **Blade Width:** The widest point of the blade measured from the tip of the tooth to the back edge of the blade.

- E. **Tooth Rake:** The angle of the tooth face from a line perpendicular to the length of the blade.
- F. **Gullet Depth:** The distance from the tooth tip to the bottom of the curved area (gullet).
- G. **Tooth Pitch:** The distance between tooth tips.
- H. **Blade Back:** The distance between the bottom of the gullet and the back edge of the blade.
- I. **Blade Pitch or TPI:** The number of teeth per inch measured from gullet to gullet.

Blade Length

Measured by the blade circumference, blade lengths are usually unique to the brand of your bandsaw and the distance between the wheels.

Model	Blade Length
G0717	119½"



Tooth Set

Three common tooth sets are alternate, wavy, and raker (see **Figure 23**). Each removes material in a different manner to make the kerf in the workpiece.

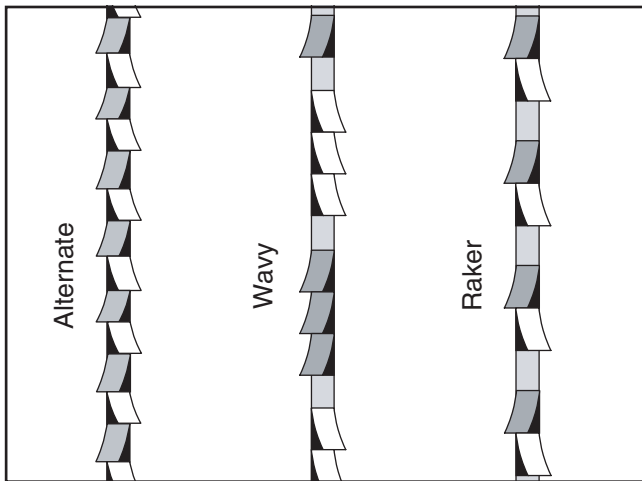


Figure 23. Bandsaw blade tooth sets.

Alternate: An all-purpose arrangement with teeth bent evenly left and right of the blade. Generally used for milder metals.

Wavy: Generally three or more teeth in a group that are bent one way, followed by a non-set tooth, and then a group bent the other way. Recommended for straight cuts in thin metals or thin-wall tubing.

Raker: Three teeth in a recurring group—one bent left, next one bent right, and then a non-set tooth. The raker set is ideal for most contour cuts.

Tooth Type

The most common tooth types are described below and illustrated in Figure 24. Each removes, gathers, and expels material differently.

Standard or Raker: Equally spaced teeth set at a "0" rake angle. Recommended for all purpose use.

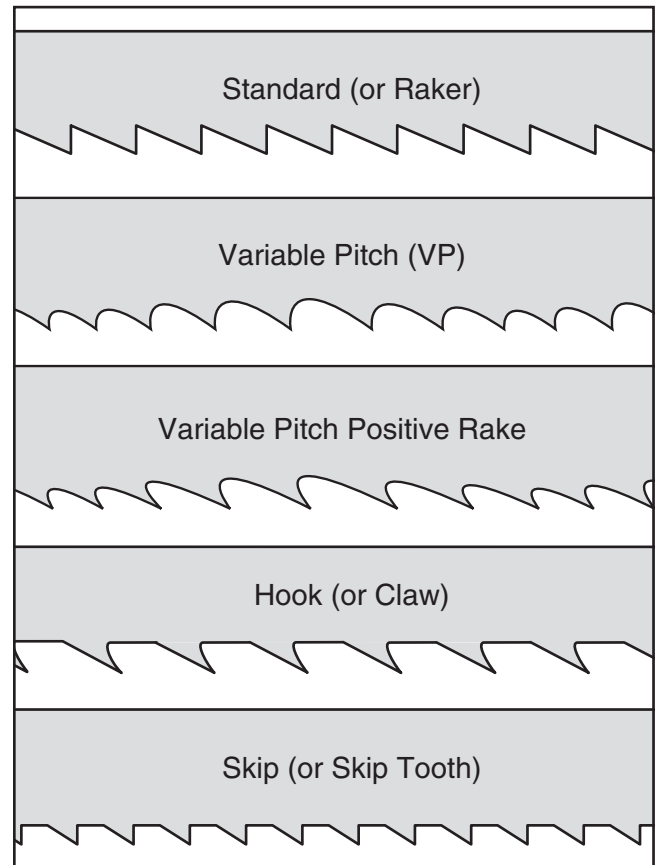


Figure 24. Bandsaw blade tooth types.

Variable Pitch (VP): Varying gullet depth and tooth spacing, a "0" rake angle, excellent chip removing capacity, and smooth cutting.

Variable Pitch with Positive Rake: Varying gullet depth and tooth spacing, a positive rake angle, better chip formation, and aggressive cutting.

Hook or Claw: Wide gullets (round or flat), equally spaced teeth, positive rake angle, and fast cut with good surface finish.

Skip or Skip Tooth: Wide, flat gullets, a "0" rake angle, equally spaced teeth, and recommended for non-ferrous materials.



Blade Pitch (TPI)

The chart below is a basic starting point for choosing teeth per inch (TPI) for variable pitch blades and standard raker set bi-metal blades/HSS blades. However, for exact specifications of bandsaw blades that are correct for your operation, contact the blade manufacturer.

To select the correct blade pitch:

1. Measure the material thickness. This measurement is the distance from where each tooth enters the workpiece to where it exits the workpiece.
2. Refer to the "Material Width/Diameter" row of the blade selection chart in Figure 25, and read across to find the workpiece thickness you need to cut.

3. Refer to the "Material Shapes" row and find the shape of the material to be cut.
4. In the applicable row, read across to the right and find the box where the row and column intersect. Listed in the box is the minimum TPI recommended for the variable tooth pitch blades.
5. The "Cutting Speed Rate Recommendation" section of the chart offers guidelines for various metals, given in feet per minute (FPM). Choose the speed closest to the number shown in the chart.

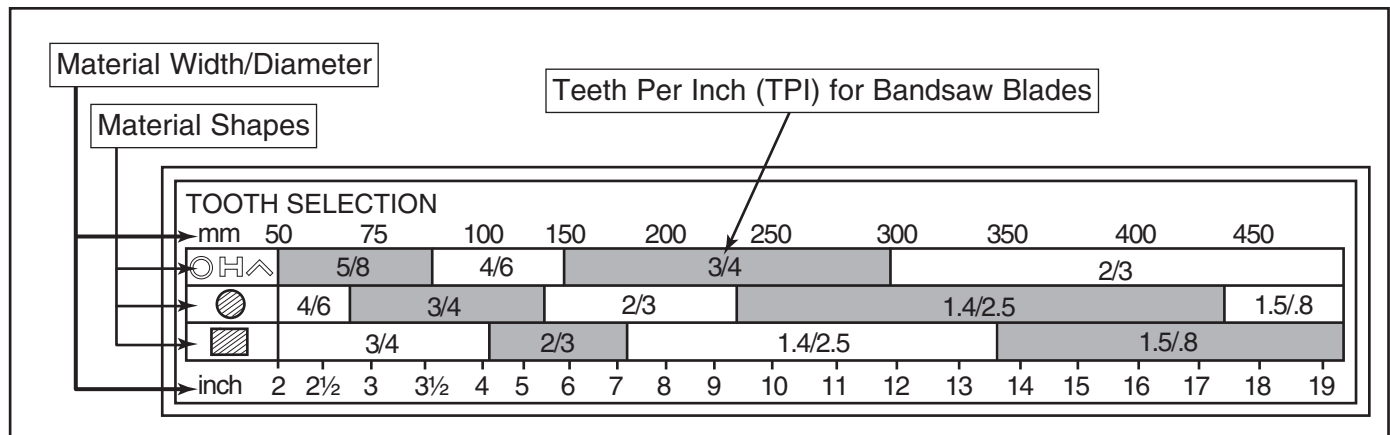


Figure 25. General guidelines for blade selection and speed chart.



Blade Change

⚠ CAUTION

**CUTTING HAZARD! Blades are sharp!
Wear heavy leather gloves to prevent cuts
when handling blades.**

Blades should be changed when they become dull, damaged, or when you are using materials that require a blade of a certain type or tooth count.

To change the blade on the bandsaw:

1. UNPLUG THE BANDSAW!
2. Raise the bow of the bandsaw about six inches, then lock it in position by turning the feed control knob to the right.
3. Loosen and slide both blade guides toward the center of the bow.
4. Remove the the upper blade guard (see **Figure 26**).

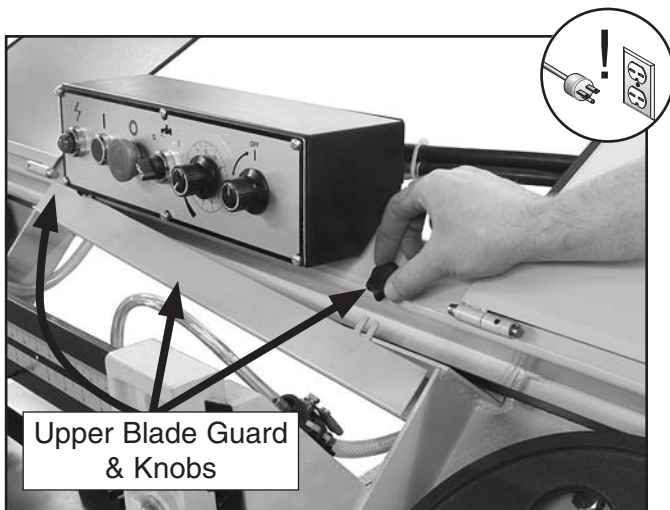


Figure 26. Removing upper blade guard.

5. Open both wheel covers and clean out all the chips and shavings.
6. Loosen the blade tension handwheel and slip the old blade off of the wheels then out of the blade guide roller bearings.
7. Install the new blade into the front and rear blade guide roller bearings, as shown in **Figure 27**, then around the bottom and top wheels.

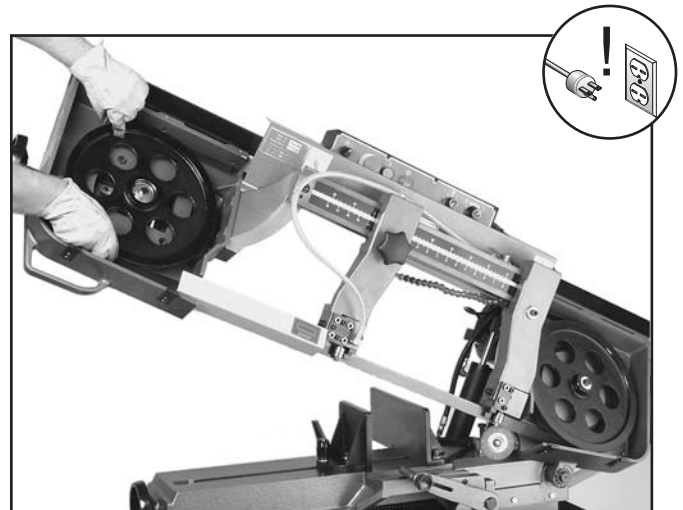


Figure 27. Typical blade installation.



Note: It is sometimes possible to flip the blade inside out, in which case the blade will be installed in the wrong direction. Check to make sure the blade teeth are facing toward the workpiece, as shown in **Figure 28**, after mounting on the bandsaw. Some blades will have a directional arrow as a guide.

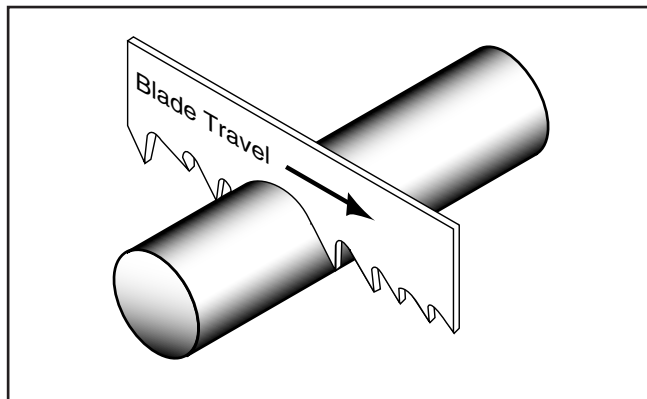


Figure 28. Blade cutting direction.

8. Apply a light amount of tension to hold the blade in place. Work your way around the blade to adjust the position so the back of the blade is within $\frac{1}{16}$ " of the flange of the wheels.
9. Complete the blade change by following the steps in **Blade Tension & Blade Tracking, on this page & Page 28.**

Blade Tension

Proper tension is essential to avoid blade vibration, twist, or slippage on the wheels. A correctly tensioned blade provides long life, straight cuts, and efficient cutting times.

The three major signs of incorrect blade tension are: 1) The blade stalls in the cut and slips on the wheels, 2) the blade frequently breaks, and 3) the bandsaw does not make straight cuts.

To tension the blade on the bandsaw:

1. Make sure the blade is tracking properly.
2. **DISCONNECT BANDSAW FROM POWER!**
3. Loosen and slide the blade guide as far out as it will go, then tighten it down again.
4. Turn the tension handwheel in **Figure 29** clockwise to tighten the blade or clockwise to loosen the blade.

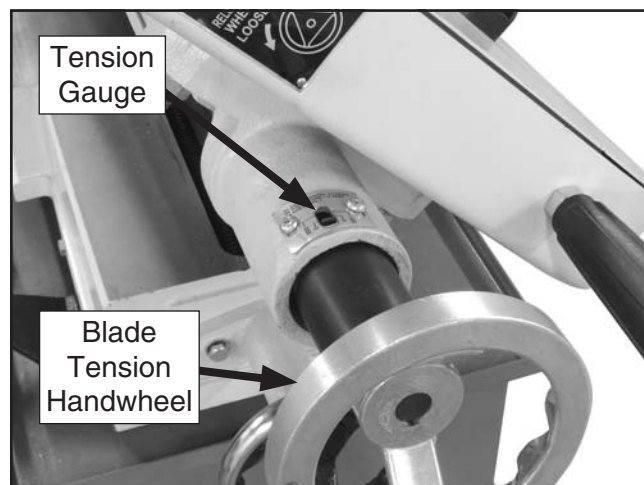


Figure 29. Adjusting blade tension.

5. Tighten the blade until the tension gauge moves into the green section.



Blade Tracking

The blade tracking has been properly set at the factory. The tracking will rarely need to be adjusted if the bandsaw is used properly.

To adjust the blade tracking on the bandsaw, loosen or tighten the tracking adjustment bolt and lock nut in **Figure 30** until the blade is tracking properly. The blade is tracking properly when the back of the blade is approximately $\frac{1}{16}$ " away from the flange of both wheels.

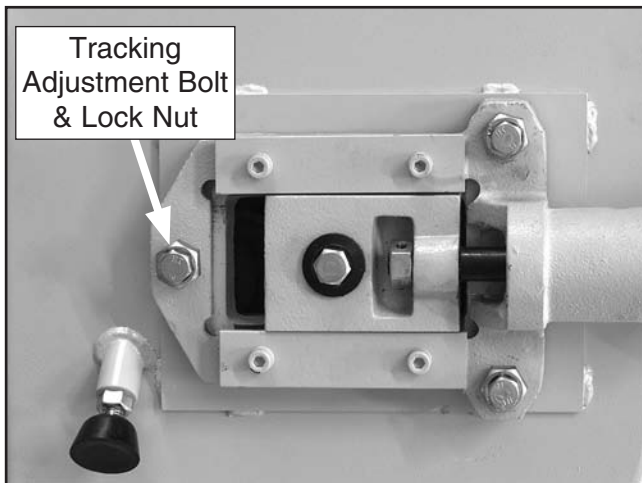


Figure 30. Tracking set screw.

Blade Breakage

Many conditions may cause a bandsaw blade to break. Some of these conditions are unavoidable and are the natural result of the stresses placed on the bandsaw; other causes of blade breakage are avoidable.

The most common causes of avoidable blade breakage are:

- Faulty alignment or adjustment of the blade guides.
- Forcing or twisting a wide blade around a tight radius.
- Feeding the workpiece too fast.
- Dull or damaged teeth.
- Over-tensioned blade.
- Top blade guide assembly set too high above the workpiece. Adjust the top blade guide assembly so that there is approximately $\frac{1}{8}$ "– $\frac{1}{4}$ " between the bottom of the assembly and the workpiece. Understand that with smaller workpieces, this may not be possible. In these cases, simply adjust the blade guide as far down as possible.
- Using a blade with a lumpy or improperly finished braze or weld.
- Continuously running the bandsaw when not in use.
- Leaving the blade tensioned when not in use.
- Using the wrong blade pitch (TPI) for the workpiece thickness. The general rule of thumb is to have no fewer than three teeth in contact with the workpiece when starting a cut and at all times during cutting.



Blade Care & Break-In

Blade Care

To prolong blade life, always use a blade with the proper width, set, type, and pitch for each application. Maintain the appropriate feed rate, feed pressure, and blade speed and pay attention to the chip characteristics (Refer to the **Chip Inspection Chart** on **Page 31**). Keep your blades clean, since dirty or gummed up blades pass through the cutting material with much more resistance than clean blades, causing unnecessary heat.

Blade Break-In

The tips and edges of a new blade are extremely sharp. Cutting at too fast of a feed rate or too slow of a blade speed can fracture these tips and edges, quickly dulling the blade. Properly break-in a blade allows these sharp edges to wear without fracturing, thus keeping the blade sharp longer. Below is a typical break-in procedure. For aftermarket blades, refer to the manufacturer's break-in procedure to keep from voiding the warranty.

Use the **Chip Inspection Chart** on **Page 31** as a guide to evaluate the chips and ensure that the optimal blade speed and feed rate are being used.

To properly break-in a new blade:

1. Choose the correct speed for the blade and material of the operation.
2. Reduce the feed pressure by half for the first 50–100 square inches of material cut.
3. To avoid twisting the blade when cutting, adjust the feed pressure when the total width of the blade is in the cut.

Downfeed

Downfeed is controlled by two knobs on the control panel.

To set the feed rate:

1. Raise the bow to the highest position.
2. Set the Downfeed Rate Knob in **Figure 31** to the desired feed rate.

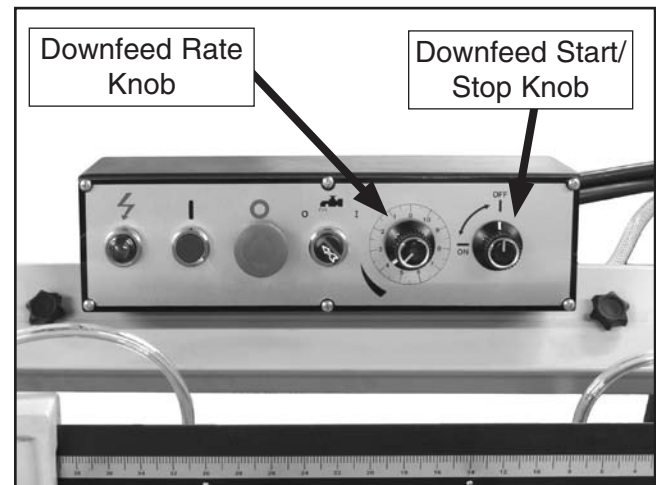


Figure 31. Feed rate controls.

3. Turn the downfeed start/stop knob to the left to lower the bow at the feed rate you have set. Turning the knob to the right locks the bow in position.



Downfeed Pressure

The downfeed pressure is controlled by the spring shown in **Figure 32**.

To decrease downfeed pressure, turn the hex nut clockwise to increase spring tension. To increase downfeed pressure, turn the hex counterclockwise to release spring tension. After adjustments, tighten the lock nut against the bracket to secure the spring setting.

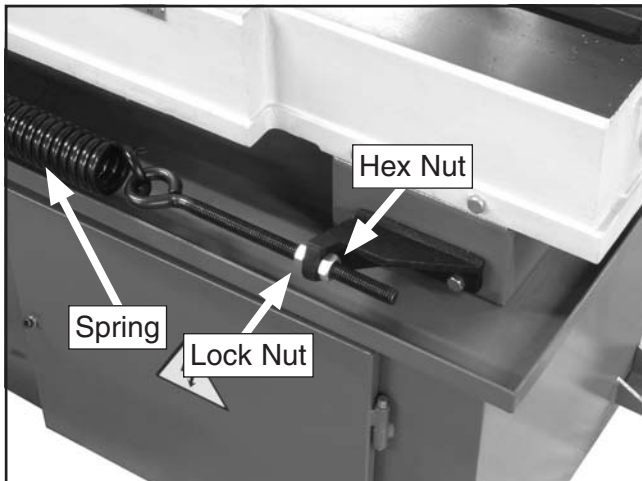


Figure 32. Downfeed rate adjustment.

Blade Speed

The Model G0717 has four speed settings—83, 132, 170, and 235 feet per minute (FPM). Refer to the chart on **Page 25** for cutting speed recommendations by material type.

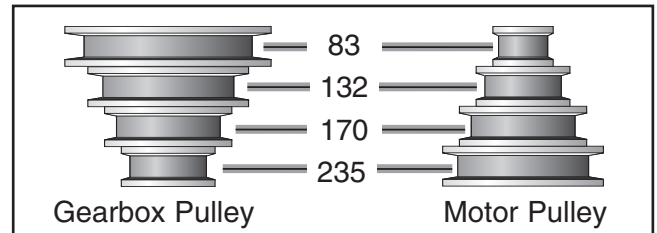


Figure 33. V-belt positions in FPM.

To change blade speeds:

1. UNPLUG THE BANDSAW!
2. Open the belt cover.
3. With one hand, support the weight of the motor; with the other hand, loosen the hex bolt shown in **Figure 34**. The motor will drop and the V-belt will slacken.

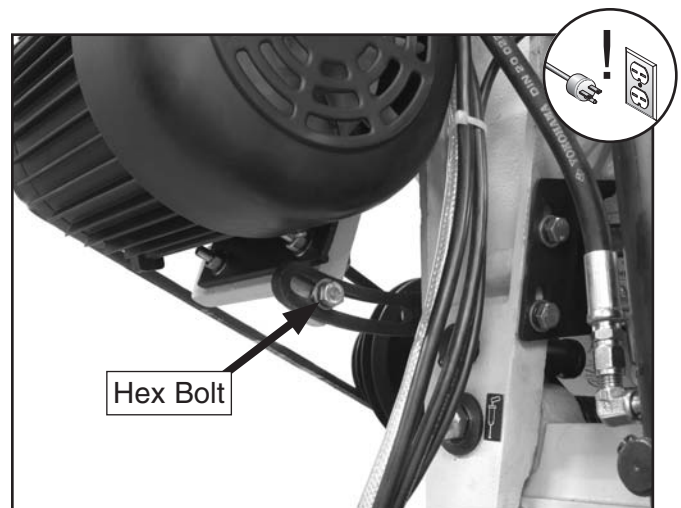


Figure 34. Belt tension bolt.

4. Move the V-belt to the desired pulley combination (see **Figure 33**, above).
5. Lift the motor to tension the belt (refer to **V-Belt** on **Page 43**) and tighten the hex bolt.
6. Close the belt cover.



Chip Inspection Chart

The best method for choosing the cutting speed and feed rate for a cutting operation is to inspect the chips created by the cut. These chips are indicators of what is commonly referred to as the "chip load." Refer to the chip inspection chart below to evaluate chip characteristics and determine whether to adjust feed rate/pressure, blade speed, or both.

Chip Appearance	Chip Description	Chip Color	Blade Speed	Feed Rate/Pressure	Other Actions
	Thin & Curled	Silver	Good	Good	
	Hard, Thick & Short	Brown or Blue	Increase	Decrease	
	Hard, Strong & Thick	Brown or Blue	Increase	Decrease	
	Hard, Strong, Curled & Thick	Silver or Light Brown	Good	Decrease Slightly	Check Blade Pitch
	Hard, Coiled & Thin	Silver	Increase	Decrease	Check Blade Pitch
	Straight & Thin	Silver	Good	Increase	
	Powdery	Silver	Decrease	Increase	
	Coiled, Tight & Thin	Silver	Good	Decrease	Check Blade Pitch

Figure 35. Chip inspection chart.

Blade Speed Chart

The chart in **Figure 36** offers blade speed guidelines for various metals in feet per minute (FPM) and meters per minute (M/Min). Choose the closest available speed on the machine, then adjust the feed rate as necessary, using the appearance of the chips produced as a guide. Refer to the Chip Inspection Chart above for recommendations on adjusting feed rate or blade speed based on the appearance of the chips produced.

Material	Speed FPM (M/Min)	Material	Speed FPM (M/Min)	Material	Speed FPM (M/Min)	Material	Speed FPM (M/Min)
Carbon Steel	196~354 (60) (108)	Tool Steel	203 (62)	Alloy Steel	111~321 (34) (98)	Free Machining Stainless Steel	150~203 (46) (62)
Angle Steel	180~220 (54) (67)	High-Speed Tool Steel	75~118 (25) (36)	Mold Steel	246 (75)	Gray Cast Iron	108~225 (33) (75)
Thin Tube	180~220 (54) (67)	Cold-Work Tool Steel	95~213 (29) (65)	Water Hardened Tool Steel	242 (75)	Ductile Austenitic Cast Iron	65~85 (20) (26)
Aluminum Alloy	220~534 (67) (163)	Hot-Work Tool Steel	203 (62)	Stainless Steel	85 (26)	Malleable Cast Iron	321 (98)
Copper Alloy	229~482 (70) (147)	Oil-Hardened Tool Steel	203~213 (62) (65)	CR Stainless Steel	85-203 (26) (62)	Plastics	220 (67)

Figure 36. Dry cutting blade speed chart.



Vise

CAUTION

Always turn the saw **OFF** and allow the blade to come to a complete stop before using the vise! Failure to follow this caution may lead to injury.

The vise has a quick release feature that allows jaw width to be quickly adjusted when changing from one sized material to another.

To rapidly change the vise jaw gap:

1. Turn the handwheel counterclockwise to relieve any pressure on the vise jaw.
2. Lift the handle on the vise quick adjustment, then pull or push the jaw in the desired direction.
3. Finish tightening the jaw against the workpiece with the handwheel.

Note: *Figure 37 shows correct methods of holding different workpiece shapes.*

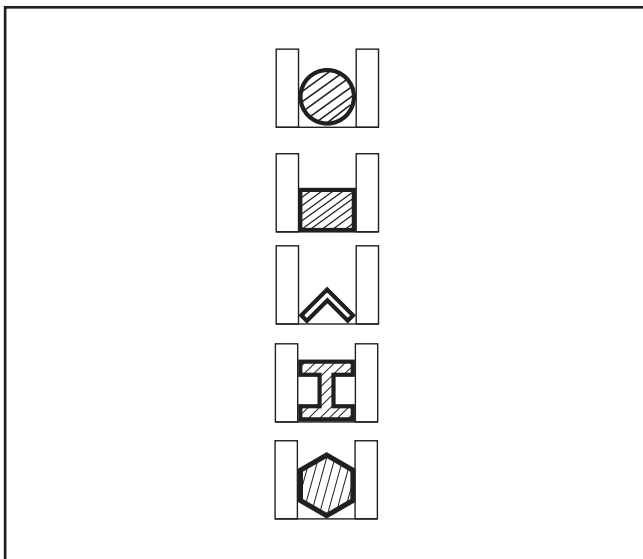


Figure 37. Workholding options by material shape.

Blade Guide Arms

The blade guide bearings are mounted on the front and rear arms. The upper arm is adjustable and should be set as close to the workpiece as possible. This will help ensure straight cuts by keeping the blade from twisting and drifting off of the cut line. It also maximizes safety by exposing only enough blade to make the cut.

To adjust the rear blade guide arm:

Loosen the knob shown in **Figure 38** and slide the rear blade guide as close to the workpiece as possible, then tighten the knob.

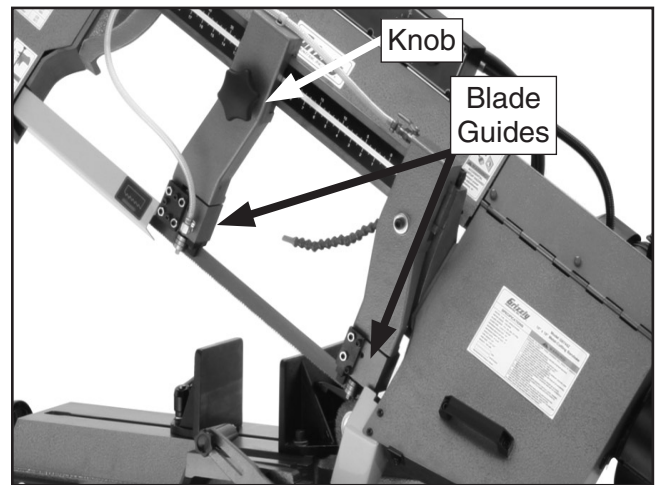


Figure 38. Typical blade guides.



Cutting Fluid


While simple in concept and function, many issues must be taken into account to find and use the correct cutting fluid. Always follow all product warnings and contact the fluid manufacturer for unanswered questions.

Use the information below as a guideline to choose the appropriate cutting fluid. Always refer to the cutting fluid manufacturer for specific application and safety information:

- For cutting low alloy, low carbon, and general-purpose category metals with a bi-metal blade—use a water soluble cutting fluid.
- For cutting stainless steels, high carbon, and high alloy metals, brass, copper and mild steels—use "Neat Cutting Oil" (commonly undiluted mineral oils) that have extreme pressure additives (EP additives).
- For cutting cast iron, cutting fluid is not recommended.

Remember: *Too much flow at the cutting fluid nozzles will make a mess and can make the work area unsafe; and not enough fluid at the cut will heat the blade, causing the blade teeth to load up and break.*

Tip: *Using a refractometer or hydrometer to replenish water in water-based coolant can extend the life of blades and coolant, and ensure consistent cutting results.*

	<p>!WARNING BIOLOGICAL AND POISON HAZARD! Use proper personal protection equipment when handling cutting fluid and follow federal, state, and fluid manufacturer requirements to properly dispose of cutting fluid.</p>
---	---

<p>!WARNING BIOLOGICAL and POISON HAZARD!</p> 
--

The reservoir on this machine is designed to store cutting fluid. During storage, some fluids grow dangerous microbes, or due to the collection of toxic metal chips in the fluid, the fluid can become a potent and extremely poisonous solution to humans and animals.

USE the correct personal protection equipment when handling cutting fluids to prevent infections and poisoning.

USE a good bactericide and fungicide for additional protection.

FOLLOW federal, state, and the fluid manufacturer requirements to properly dispose of cutting fluid when it becomes unsafe.

<p>NOTICE</p> <p>Clean coolant system with a bactericide and fungicide between coolant changes to prevent recontamination.</p>



Cutting Fluid System



This bandsaw has a built-in cutting fluid system that extends the life of your bandsaw blades by lowering the temperature of the blade and workpiece when cutting.

See **Cutting Fluid** on **Page 33** for additional information.

To use the cutting fluid system:

1. Access the reservoir by removing the rear panel on the base (see **Figure 39**).

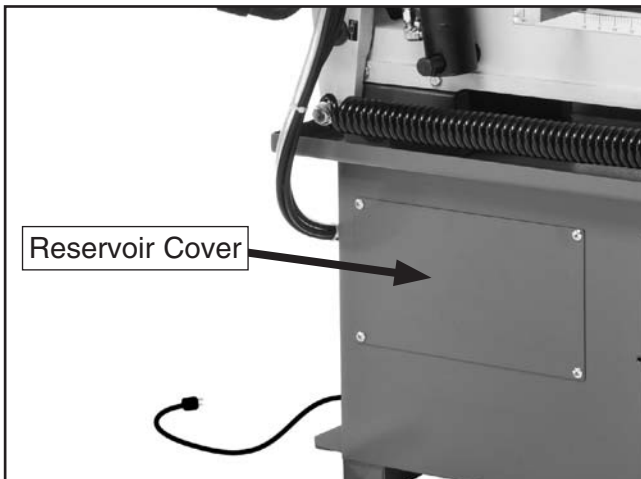


Figure 39. Cutting fluid system reservoir cover.

2. Thoroughly clean and remove any foreign material that may have fallen inside the reservoir during shipping.
3. Fill the reservoir with your chosen cutting fluid solution and replace the rear panel.
4. Make sure the cutting fluid control valve is turned **OFF**.
5. Turn the cutting fluid pump switch **ON** before making your cut.
6. Adjust the valve on the coolant hose to control the flow of cutting fluid (see **Figure 40**). Make sure that the pressure is not so high that cutting fluid spills on the floor and creates a slipping hazard.

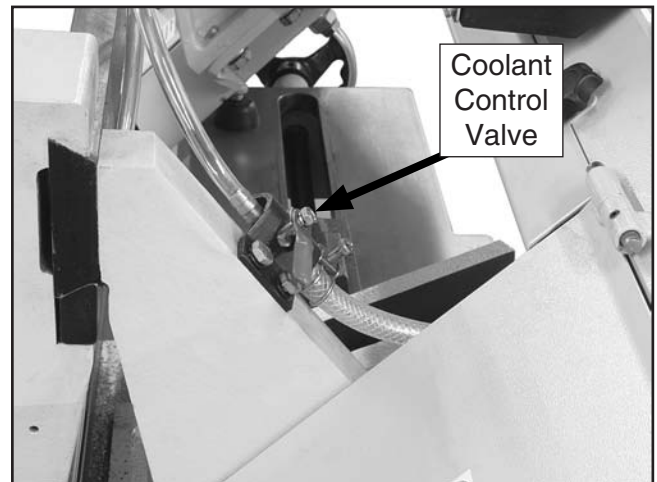


Figure 40. Coolant control valve.

7. When the bandsaw reaches the bottom of the cut, the motor and cutting fluid system will shut **OFF**.

NOTICE

Keep the tray chip screen clear so cutting fluid can recycle to the pump reservoir. **NEVER** operate the pump with the reservoir below the low mark or you will overheat the pump and void your warranty!



You need to change coolant when you notice the following conditions:

- Low sump level
- Abnormal fluid appearance (change in color)
- Foul smell (rancidity)
- Floating matter on the fluid (chips, swarf, mold)
- Tramp oil floating on the surface (leaking machine and hydraulic oils)
- Excessive foam (improper mixture, too high of pressure, excessive air in system)
- Dirty machine or trenches (cleaners in the fluid have become depleted)
- User notices skin irritation
- User has respiratory irritation
- Other problems that might be fluid related are:
 - rust on machine or part
 - staining on machine or part
 - tool failure due to loss of coolant performance
 - growth of fungi that would block coolant flow
 - change in coolant viscosity (thicker or thinner)
 - accumulation of water at the bottom of the sump in straight oils
 - dirt and grit suspended in coolant
 - general loss of performance (burning part or tool)

Consult your coolant manufacturer and MSDS for complete use and disposal information.

Blade Brush

The lower blade guide arm has a self-adjusting wire brush that makes contact with the blade to help clear away chips and extend blade life (see **Figure 41**).

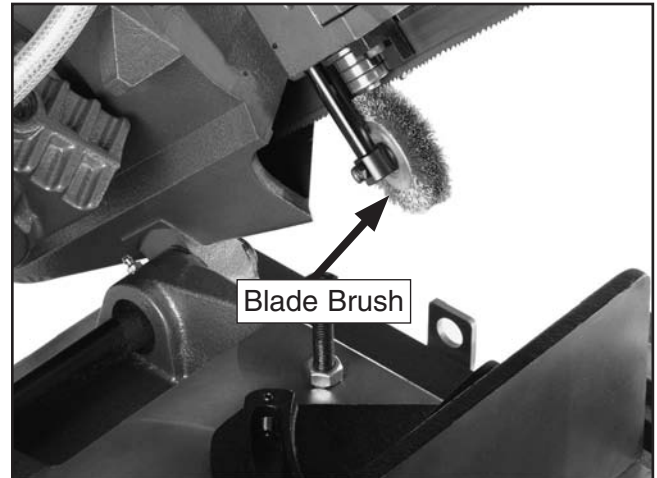


Figure 41. Typical blade brush.



Operation Tips

The following tips will help you safely and effectively operate your bandsaw, and help you get the maximum life out of your saw blades.

- Use the work stop to quickly and accurately cut multiple pieces of stock to the same length.
- Clamp the material firmly in the vise jaws to ensure a straight cut through the material, and use the positive lock to speed production.
- Let the blade reach full speed before engaging the workpiece.
- Never start a cut with the blade in contact with the workpiece, and do not start a cut on a sharp edge.
- Pay attention to the chips produced by the cutting operation and use their appearance to fine-tune the blade speed, feed speed, and pressure (refer to the **Chip Inspection Chart** on **Page 31**).

- Wait until the blade has completely stopped before removing the workpiece from the vise, and avoid touching the cut end—it could be very hot!
- Support long pieces so they won't fall when cut, and flag the ends to alert passers-by of potential danger.
- Adjust the blade guides as close as possible to the workpiece to minimize side-to-side blade movement.
- Use coolant when possible to increase blade life.

NOTICE

Loosen blade tension at the end of each day to prolong blade life.



SECTION 5: ACCESSORIES

Tool Steel Blades

G6432—129³/₈ x 1 x .032 10 TPI Raker

G6433—129³/₈ x 1 x .032 14 TPI Raker

Variable Pitch Bi-Metal Blades

G6434—129³/₈ x 1 x .032 3-4 Variable Pitch

G6435—129³/₈ x 1 x .032 4-6 Variable Pitch

G6436—129³/₈ x 1 x .032 5-8 Variable Pitch

G6437—129³/₈ x 1 x .032 6-10 Variable Pitch

G6438—129³/₈ x 1 x .032 8-12 Variable Pitch

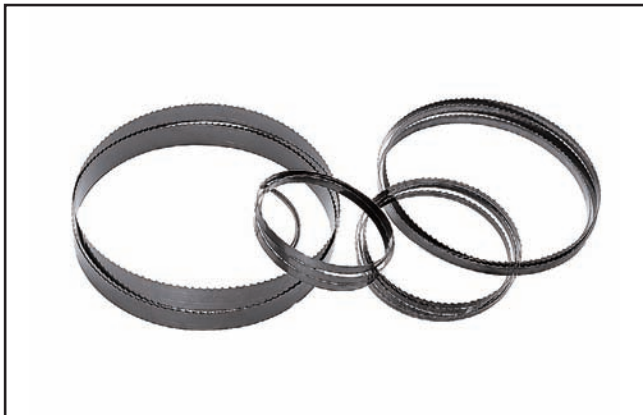


Figure 42. Blades.

H5408—Blade Tensioning Gauge

The Blade Tensioning Gauge ensures long blade life, reduced blade breakage, and straight cutting by indicating correct tension. A precision dial indicator provides you with a direct readout in PSI.



Figure 43. H5408 Blade Tensioning Gauge.

H9240—Water Soluble Machining Oil

Rustlick water soluble machining oil contains effective chlorinated E.P. additive to provide excellent tool life. Guaranteed to protect neoprene seals. Great for general purpose or heavy duty applications. Can be used on all metals except titanium.



Figure 44. H9240 Rustlick Machining Oil.

H9231—Safe Tap™ Stick, 13 oz.

A natural lubricant in a convenient stick form that can be used on grinding wheels to allow them to cut freely and improve wheel life. SafeTap™ Stick is excellent for belt-grinding applications, giving better finishes and increased belt life. SafeTap™ Stick can also be used on saw blades to improve blade life.



Figure 45. H9231 Safe Tap™ Stick, 13 oz.

Call 1-800-523-4777 To Order



G5618—Deburring Tool with Two Blades

G5619—Extra Aluminum Blades

G5620—Extra Brass and Cast Iron Blade

The quickest tool for smoothing freshly machined metal edges. Comes with two blades—one for steel/aluminum and one for brass/cast iron.



Figure 46. G5618 Deburring Tool.

Basic Eye Protection

T20501—Face Shield Crown Protector 4"

T20502—Face Shield Crown Protector 7"

T20503—Face Shield Window

T20452—"Kirova" Anti-Reflective S. Glasses

T20451—"Kirova" Clear Safety Glasses

H0736—Shop Fox® Safety Glasses

H7194—Bifocal Safety Glasses 1.5

H7195—Bifocal Safety Glasses 2.0

H7196—Bifocal Safety Glasses 2.5



Figure 47. Assortment of basic eye protection.

H4978—Deluxe Earmuffs - 27dB

H4979—Twin Cup Hearing Protector - 29dB

T20446—Ear Plugs 200 Pair - 31dB

Protect your hearing before its too late. Especially important if you or employees operate for hours at a time.



Figure 48. Hearing protection assortment.

G9256—6" Dial Caliper

G9257—8" Dial Caliper

G9258—12" Dial Caliper

These traditional dial calipers are accurate to 0.001" and can measure outside surfaces, inside surfaces, and heights/depths. Features stainless steel, shock resistant construction and a dust proof display.

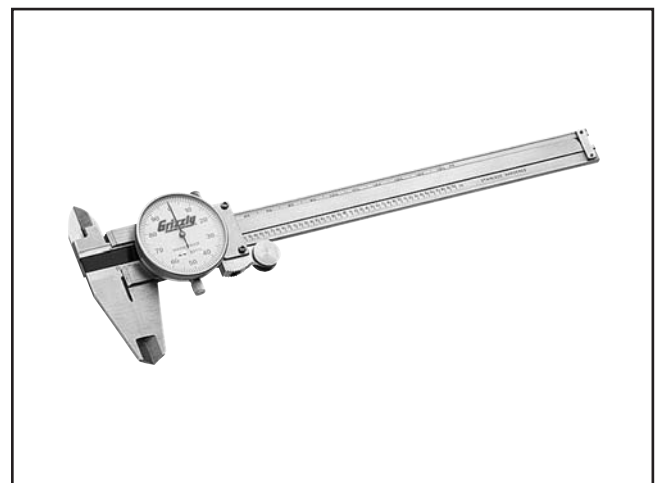


Figure 49. Grizzly® Dial Calipers.

Call 1-800-523-4777 To Order



SECTION 6: MAINTENANCE



Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check:

- Loose mounting bolts.
- Damaged saw blade.
- Worn or damaged wires.
- Any other unsafe condition.
- Clean after each use.
- Proper blade tension.
- Coolant level.
- Coolant condition.

Monthly Check:

- Lubricate vise screw.
- Check gear box fluid level.

Annual Check:

- Change gear box oil (every four months if being used daily).

Cleaning

Cleaning the Model G0717 is relatively easy. After using your bandsaw, remove excess chips by sweeping. Then remove chips for recycling.

Wipe down the machine and remove any standing coolant.

Lubrication

Since all bearings are sealed and permanently lubricated, leave them alone until they need to be replaced. Do not lubricate them. However, you must periodically lubricate threaded adjustment locations and check the gear box oil level.

Lubricate the following areas as follows:

- **Blade Tension Mechanism:** Apply a few drops of oil on the tension knob lead screw (see **Figure 50**).

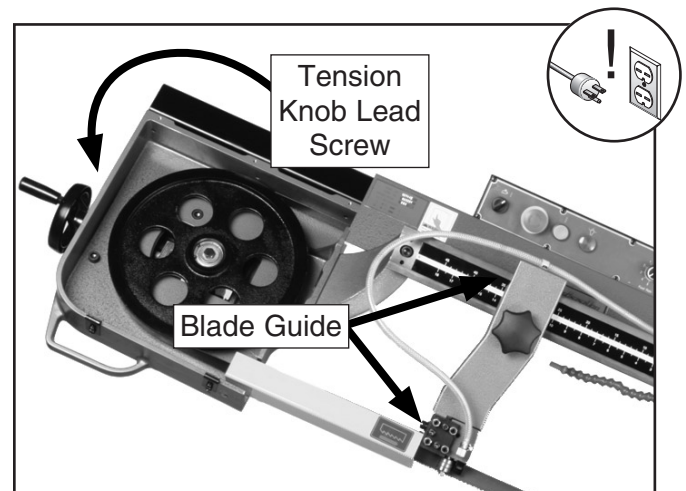


Figure 50. Typical main lubrication points.

- **Blade and Guides:** Drop a few drops of light machine oil on the blade and the blade guides daily, especially when cutting cast iron, as no cutting fluid is recommended (see **Figure 50**).



- **Table and Machined Surfaces:** Tables can be kept rust-free with regular applications of products like SLIPIT®. For long term storage you may want to consider products like Boeshield T-9™.
- **Vise Leadscrew:** Place a few drops of light machine oil on the vise leadscrew weekly (see **Figure 51**).



Figure 51. Typical vise leadscrew lubrication area.

- **Grease Fittings on Pivot Point:** Grease these with general purpose grease as needed to keep the pivot moving freely (see **Figure 52**).

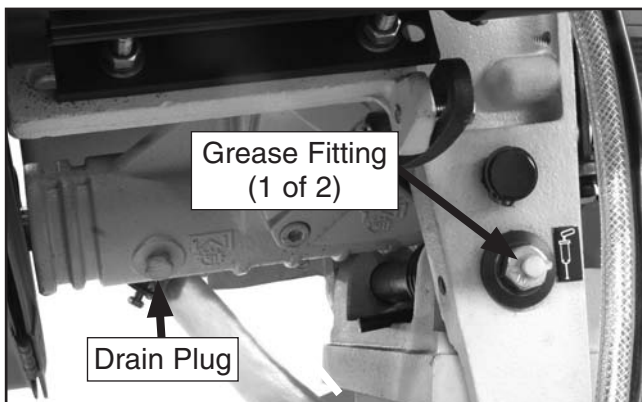


Figure 52. Lubrication points.

The gearbox should be drained and refilled after the first 50 hours of use and then once every year. Use a high quality, ISO 68 or SAE 90 gear oil.

To change the gear oil:

1. Run the bandsaw for a couple of minutes to warm up the oil in the gearbox.
2. UNPLUG THE BANDSAW!
3. Raise the bow to the highest angle and close the feed control knob to lock the bow in position.
4. Drain the gearbox by removing the drain plug shown in **Figure 52**.
5. Replace the drain plug, then lower the bow to its lowest position.
6. Open the fill cap and fill the gearbox with oil until you see the oil level reach the halfway point in the sight glass (see **Figure 53**).

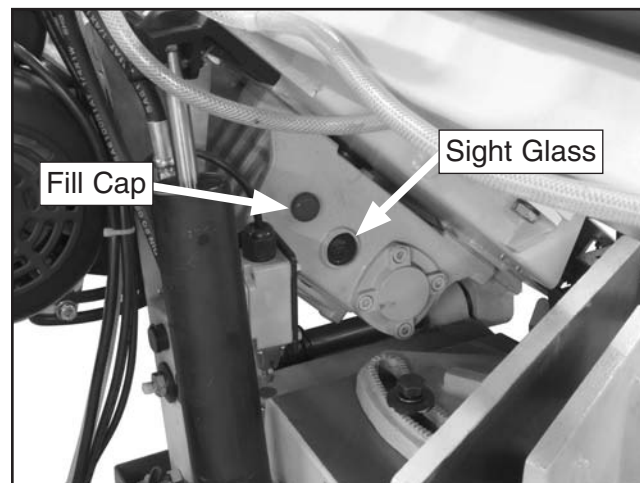


Figure 53. Gear box.

7. Tighten the fill plug, connect the machine to power and run the saw for a minute or two, then check the oil level. Add more oil if needed to maintain the level at the halfway mark in the sight glass.

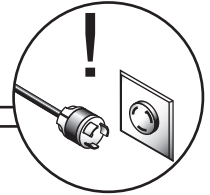


SECTION 7: SERVICE

Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support at (570) 546-9663.

Note: Please gather the serial number and manufacture date of your machine before calling.

Troubleshooting



Motor & Electrical

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> Emergency-Stop button pressed. Plug/receptacle is at fault or wired incorrectly. Start capacitor is at fault. Wall fuse/circuit breaker is blown/tripped. Motor connection wired incorrectly. Power supply is at fault/switched OFF. Motor ON/OFF switch is at fault. Wiring is open/has high resistance. Motor is at fault. 	<ol style="list-style-type: none"> Twist Emergency-Stop button until it pops out. Test for good contacts; correct the wiring. Test/replace capacitor if faulty. Ensure correct size for machine load; replace weak breaker. Correct motor wiring connections. Ensure hot lines have correct voltage on all legs and main power supply is switched ON. Replace faulty ON/OFF switch. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. Test/repair/replace.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> Wrong blade for the workpiece material. Wrong workpiece material. Feed rate/cutting speed too fast for task. Blade is slipping on wheels. Low power supply voltage. Motor bearings are at fault. Plug/receptacle is at fault. Motor connection is wired incorrectly. Motor has overheated. Motor is at fault. 	<ol style="list-style-type: none"> Use blade with correct properties for your type of cutting. Use metal with correct properties for your type of cutting. Decrease feed rate/cutting speed. Adjust blade tracking and tension. Ensure hot lines have correct voltage on all legs. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. Test for good contacts; correct the wiring. Correct motor wiring connections. Clean off motor, let cool, and reduce workload. Test/repair/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> Motor fan is rubbing on fan cover. Blade is at fault. Gearbox is at fault. Wrong blade for material. Speed is set too slow. 	<ol style="list-style-type: none"> Replace dented fan cover; replace loose/damaged fan. Replace/resharpen blade. Rebuild gearbox for bad gear(s)/bearing(s). Change blade. Adjust speed as required.



Bandsaw Operations



SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Machine is loud when cutting or bogs down in the cut.	<ol style="list-style-type: none"> Excessive feed rate. The blade TPI is too great, or the material is too coarse. 	<ol style="list-style-type: none"> Refer to Feed Rate on Page 29, or Blade Speed on Page 30 and adjust as required. Refer to Blade Selection on Page 23 and adjust as required.
Blades break often.	<ol style="list-style-type: none"> Blade is not tensioned correctly. The workpiece is loose in the vise. The feed or cut speed is wrong. The blade TPI is too great, or the material is too coarse. The blade is rubbing on the wheel flange. The bandsaw is being started with the blade resting on the workpiece. The guide bearings are misaligned, too tight, or the blade is rubbing on the wheel flange. The blade is too thick, or the blades are of low quality. 	<ol style="list-style-type: none"> Check to see that blade is not excessively tight or too loose. Clamp the workpiece tighter, or use a jig to hold the workpiece. Refer to Feed Rate on Page 29, or Blade Speed on Page 30 and adjust as required. Refer to Blade Selection on Page 23, and adjust as required. Refer to Blade Tracking on Page 28, and adjust as required. Start bandsaw and then slowly lower the headstock by setting the feed rate. Refer to Blade Tracking on Page 28, or Blade Guide Arms on Page 32, and adjust as required. Use a higher quality blade.
Blade dulls prematurely.	<ol style="list-style-type: none"> The cutting speed is too fast. The blade TPI is too coarse. The blade feed pressure is too light. The workpiece has hard spots, welds, or scale is on the material. The blade is twisted. The blade is slipping on the wheels. 	<ol style="list-style-type: none"> Refer to Blade Speed on Page 30 and adjust as required. Refer to Blade Selection on Page 23, and adjust as required. Refer to Feed Rate on Page 29, and adjust as required. Increase the feed pressure, and reduce the cutting speed. Replace the blade. Refer to Blade Tension on Page 27, and adjust as required.
Blade wears on one side.	<ol style="list-style-type: none"> The blade guides are worn or mis-adjusted. The blade guide slide bracket is loose. The wheels are out of alignment. 	<ol style="list-style-type: none"> Refer to Blade Guide Arms on Page 32 and replace or adjust. Tighten the blade guide bracket. Refer to Blade Tracking on Page 28, and adjust as required.
Teeth are ripping from the blade.	<ol style="list-style-type: none"> The feed pressure is too heavy and the blade speed is too slow; or the blade TPI is too coarse for the workpiece. The workpiece is vibrating in the vise. The blade gullets are loading up with chips. 	<ol style="list-style-type: none"> Refer to Blade Selection on Page 23 and decrease the feed pressure. Refer to Feed Rate on Page 29, and adjust as required. Re-clamp the workpiece in the vise, and use a jig if required. Use a coarser-tooth blade.
The cuts are crooked.	<ol style="list-style-type: none"> The feed pressure is too high. The guide bearings are out of adjustment, or too far away from the workpiece. The blade tension is low. The blade is dull. The blade speed is wrong. 	<ol style="list-style-type: none"> Refer to Feed Rate on Page 29, and adjust as required. Refer to Blade Guide Arms on Page 32 and replace or adjust. Refer to Blade Tension on Page 27, and adjust as required. Refer to Blade Change on Page 26 and replace the blade. Refer to Blade Speed on Page 30 and adjust as required.



V-Belt

If the V-belt may require periodic tightening, especially after the initial break-in period. The V-belt needs to be replaced if it shows any signs of glazing, cracking, or fraying. To tighten the belt, perform the following procedure, omitting **Step 4**.

To replace the V-belt:

1. UNPLUG THE BANDSAW!
2. Open the belt cover.
3. With one hand, support the weight of the motor. With the other hand, loosen the hex bolt shown in **Figure 54**. The motor will drop and the V-belt will slacken.

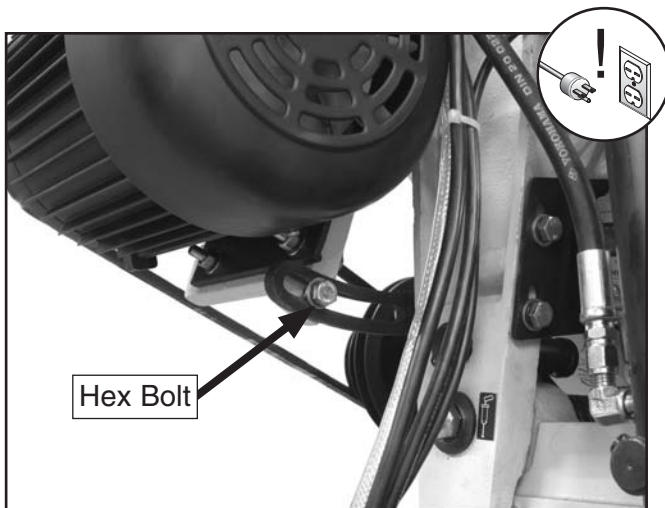


Figure 54. Belt tension bolt.

4. Remove the V-belt, then install a new belt to the desired pulley combination (refer to **Figure 33** for blade speeds).
5. Lift the motor to tension the belt and tighten the hex bolt.

—Check the belt tension. When properly tensioned, the belt will deflect approximately $\frac{1}{4}$ " , as shown in **Figure 55**, when pressed with moderate force. Adjust as necessary.

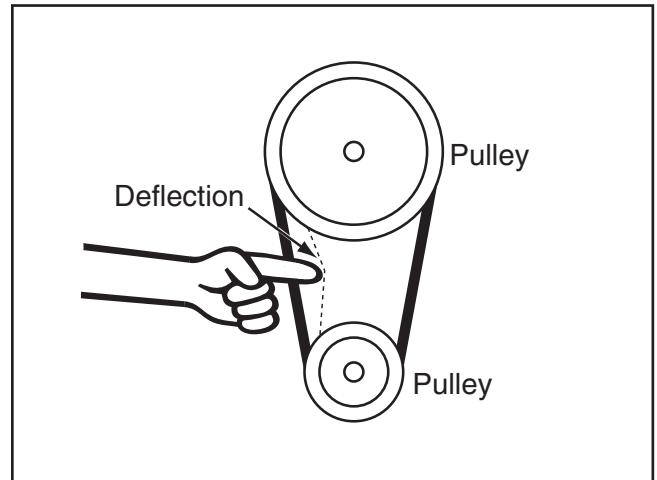


Figure 55. Proper belt tension.

6. Close the belt cover.



SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Compare the manufacture date of your machine to the one stated in this manual, and study this section carefully.

If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine. An updated wiring diagram may be available. **Note:** *Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.*

WARNING

Wiring Safety Instructions

SHOCK HAZARD. Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

MODIFICATIONS. Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved after-market parts.

WIRE CONNECTIONS. All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

CIRCUIT REQUIREMENTS. You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.
















CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

EXPERIENCING DIFFICULTIES. If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

NOTICE

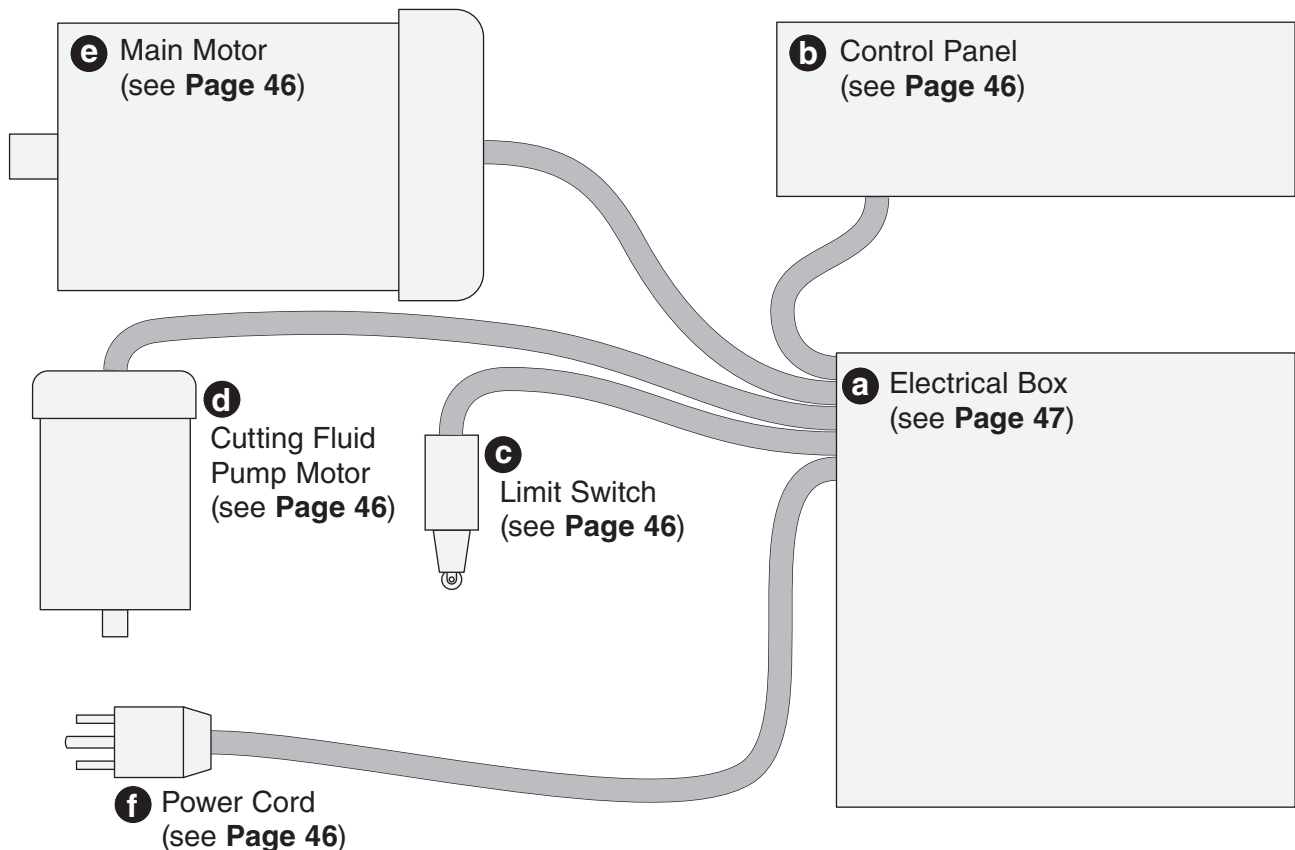
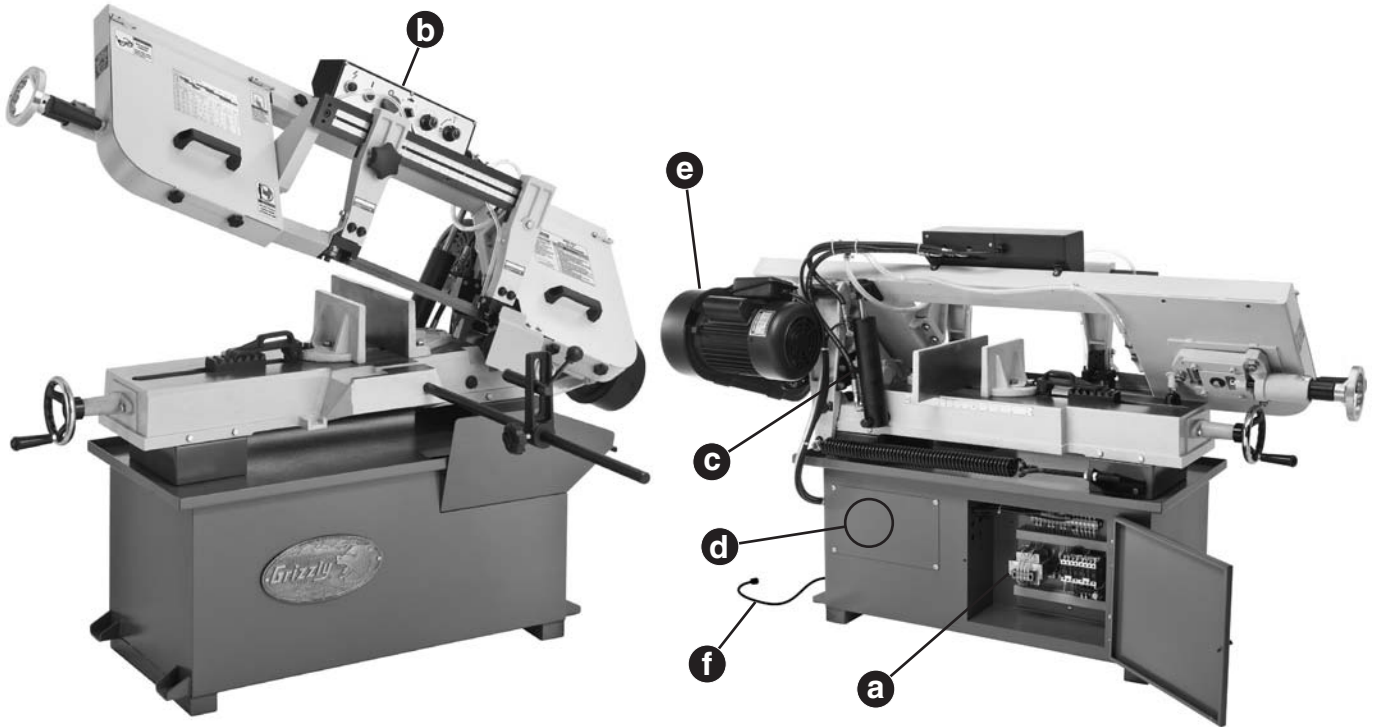
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

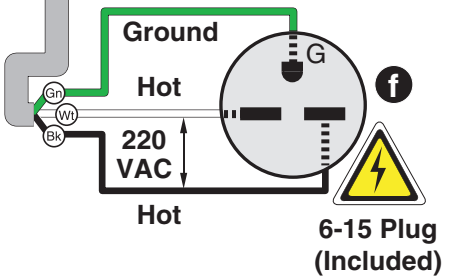
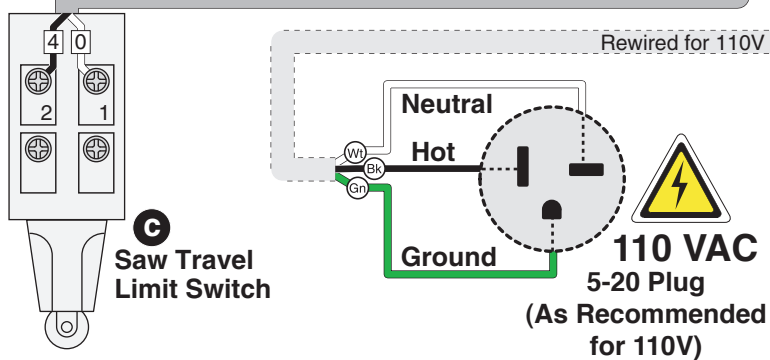
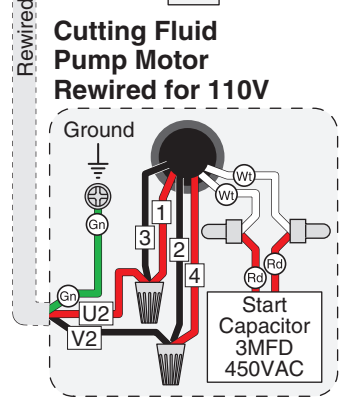
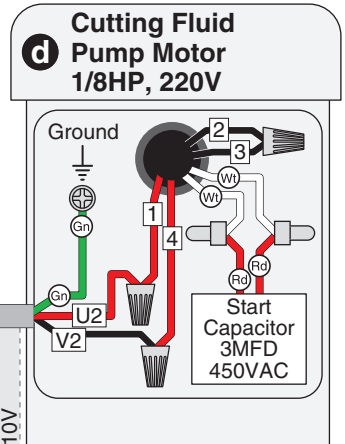
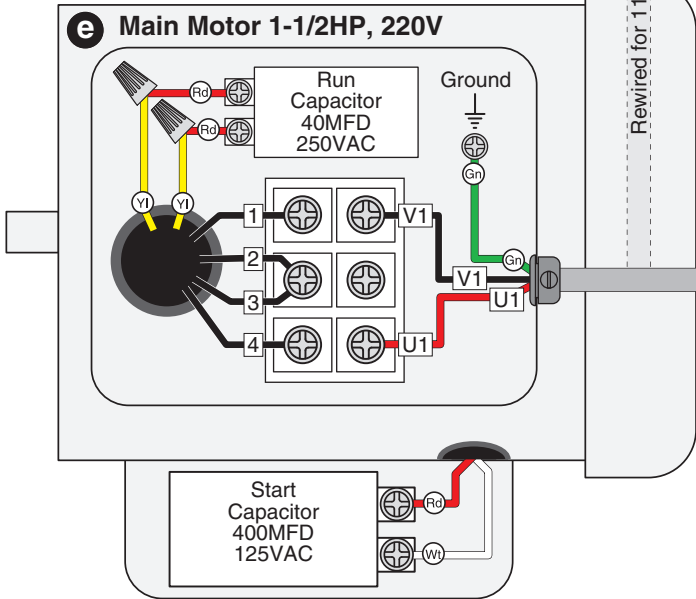
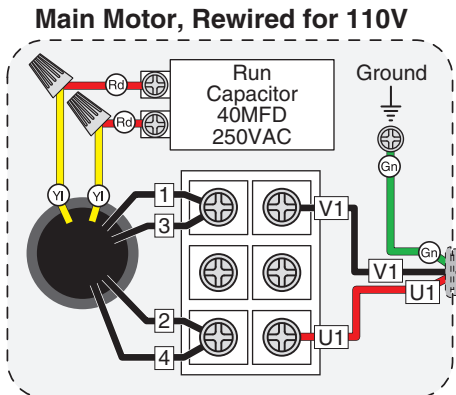
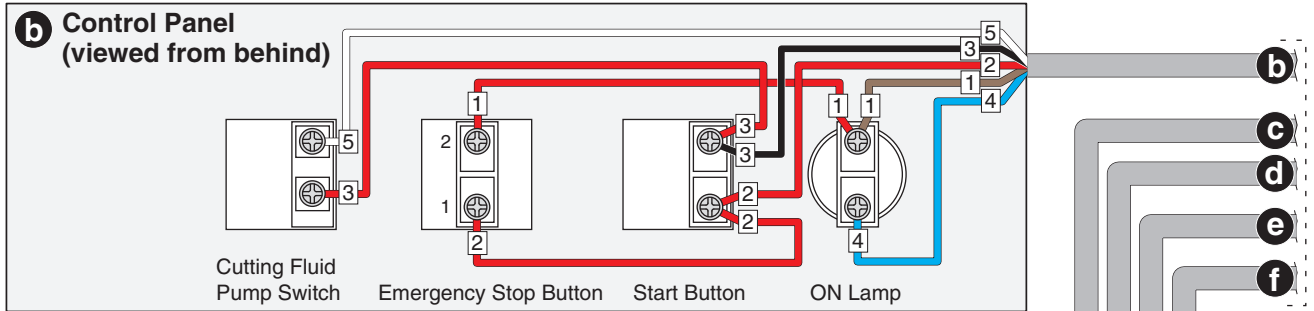
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GREEN		GRAY		PURPLE		TURQUOISE	
RED		ORANGE		PINK			



Wiring Overview



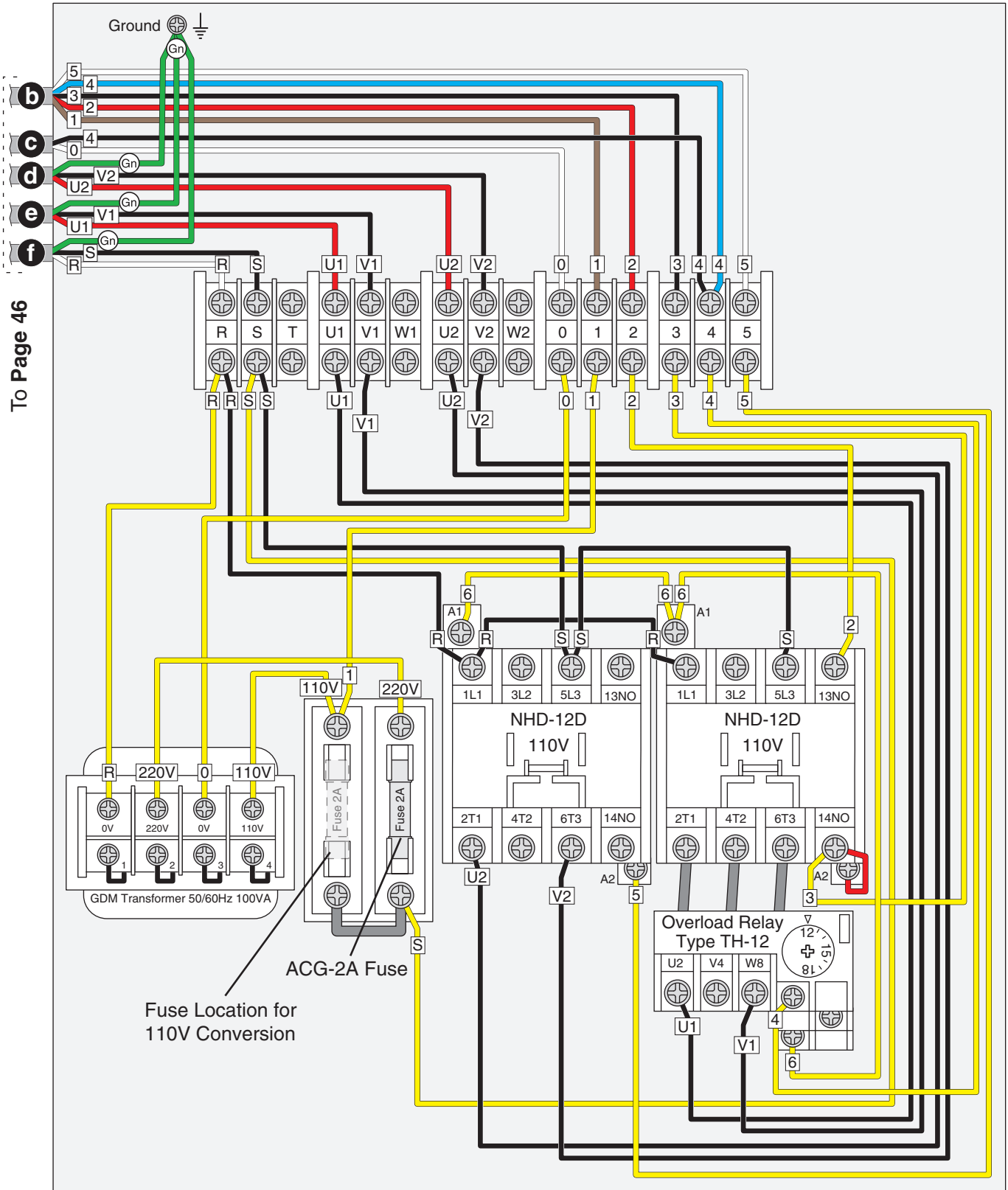
Wiring Diagram



To Page 47



a Electrical Box

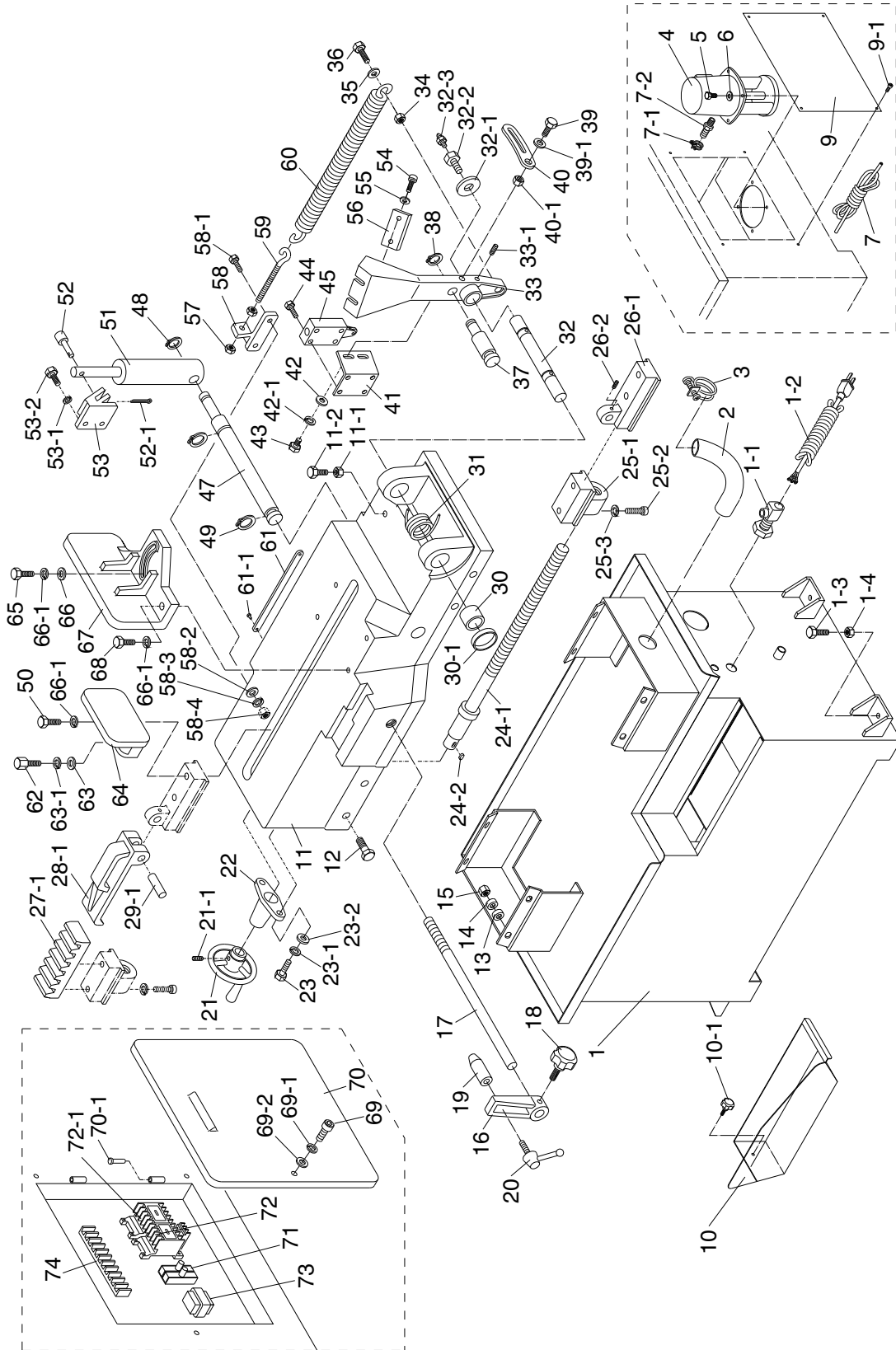


To Page 46



SECTION 9: PARTS

Base Breakdown



Base Parts List

REF	PART #	DESCRIPTION
1	P0717001	STAND
1-1	P0717001-1	STRAIN RELIEF
1-2	P0717001-2	POWER CORD 14G 3W 100" 6-15
1-3	PB125M	HEX BOLT M12-1.75 X 65
1-4	PN09M	HEX NUT M12-1.75
2	P0717002	HOSE 1 X 12"
3	P0717003	HOSE CLAMP 35MM
4	P0717004	COOLANT PUMP ASSEMBLY
5	PTH001M	TRUSS HD SCR M6-1 X 16
6	PLW03M	LOCK WASHER 6MM
7	P0717007	HOSE 5/16" X 51"
7-1	P0717007-1	HOSE CLAMP 14MM
7-2	P0717007-2	PUSH-ON HOSE FITTING 3/8 NPT-5/16"
9	P0717009	COOLANT PUMP COVER PANEL
9-1	PTH002M	TRUSS HD SCR M6-1 X 10
10	P0717010	CHIP TRAY
10-1	P0717010-1	KNOB 1/4-20 X 3/8"
11	P0717011	SAW BASE
11-1	PN02M	HEX NUT M10-1.5
11-2	PB01M	HEX BOLT M10-1.5 X 30
12	PB26M	HEX BOLT M8-1.25 X 30
13	PW01M	FLAT WASHER 8MM
14	PLW04M	LOCK WASHER 8MM
15	PN03M	HEX NUT M8-1.25
16	P0717016	WORK STOP BRACKET
17	P0717017	WORK STOP ROD
18	P0717018	KNOB 3/8-16 X 1.25
19	P0717019	WORK STOP

REF	PART #	DESCRIPTION
20	P0717020	LOCK HANDLE M12-1.25 X 24
21	P0717021	HANDWHEEL ASSEMBLY 5.5"
21-1	PSS02	SET SCREW 5/16-18 X 3/8
22	P0717022	LEAD SCREW BLOCK
23	PB26M	HEX BOLT M8-1.25 X 30
23-1	PLW04M	LOCK WASHER 8MM
23-2	PW01M	FLAT WASHER 8MM
24-1	P0717024-1	LEADSCREW
24-2	PK34M	KEY 5 X 5 X 20
25-1	P0717025-1	LEADSCREW NUT
25-2	PCAP13M	CAP SCREW M8-1.25 X 30
25-3	PLW04M	LOCK WASHER 8MM
26-1	P0717026-1	SLIDE BRACKET
26-2	PSS03M	SET SCREW M6-1 X 8
27-1	P0717027-1	WISE RACK
28-1	P0717028-1	WISE RACK PAWL
29-1	P0717029-1	WISE RACK PIN
30	P0717030	BUSHING CV 25 X 12MM
30-1	P0717030-1	SPACER
31	P0717031	TORSION SPRING
32	P0717032	PIVOT SHAFT
32-1	P0717032-1	PIVOT END CAP
32-2	P0717032-2	HOLLOW HEX BOLT M12-1.75 X 20
32-3	P0717032-3	GREASE FITTING STRAIGHT 1/16"
33	P0717033	PIVOT BRACKET
33-1	PSS13M	SET SCREW M10-1.5 X 12
34	PN09M	HEX NUT M12-1.75



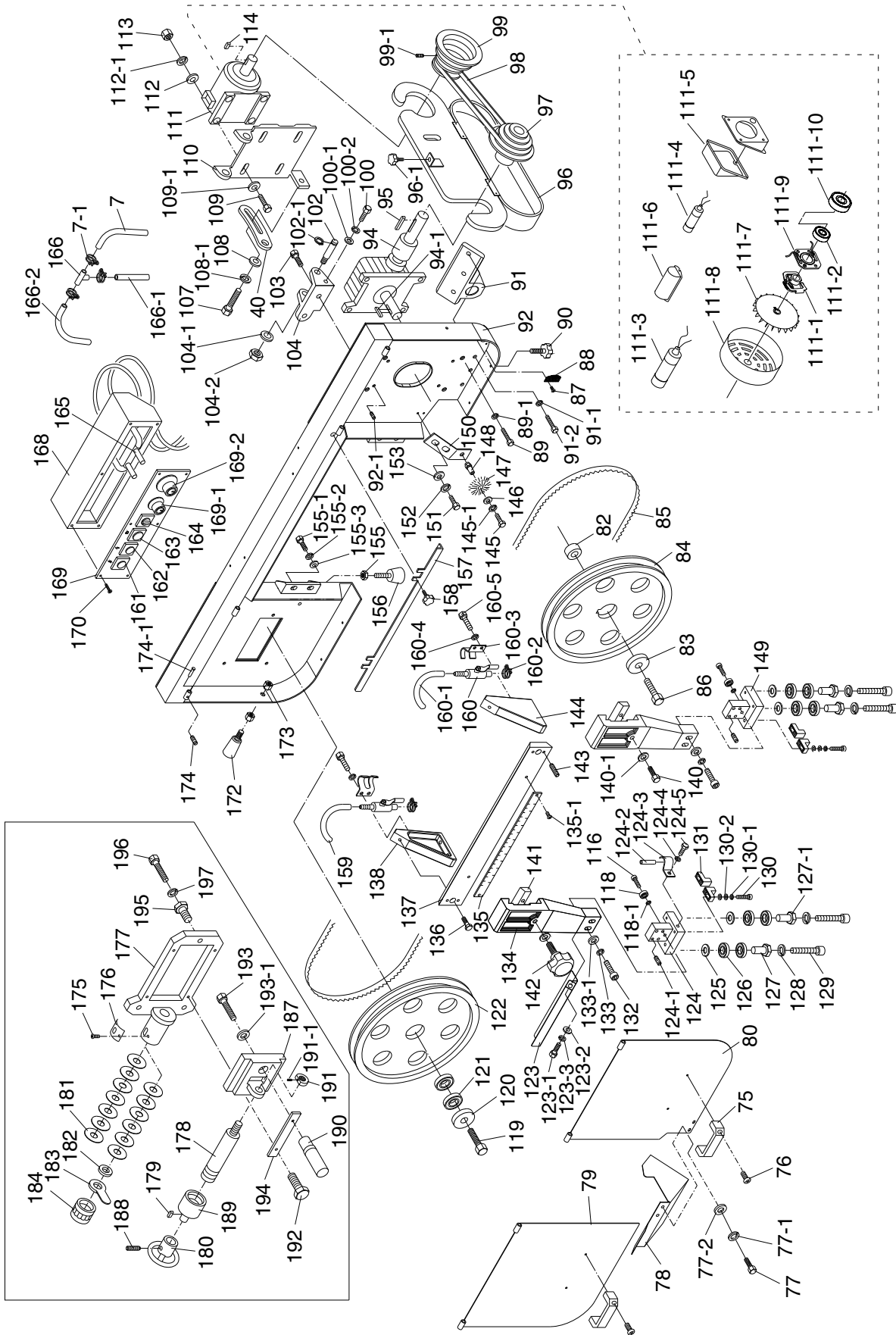
Base Parts List (continued)

REF	PART #	DESCRIPTION
35	PW06M	FLAT WASHER 12MM
36	PB35M	HEX BOLT M12-1.75 X 40
37	P0717037	TORSION SPRING SHAFT
38	PR10M	EXT RETAINING RING 22MM
39	PB26M	HEX BOLT M8-1.25 X 30
39-1	PW01M	FLAT WASHER 8MM
40	P0717040	MOTOR TILT PLATE
40-1	PN03M	HEX NUT M8-1.25
41	P0717041	LIMIT SWITCH PLATE
42	PW01M	FLAT WASHER 8MM
42-1	PLW04M	LOCK WASHER 8MM
43	PB09M	HEX BOLT M8-1.25 X 20
44	PB02M	HEX BOLT M6-1 X 12
45	P0717045	DOWNFEED LIMIT SWITCH
47	P0717047	HYDRAULIC CYLINDER MAIN PIN
48	PR09M	EXT RETAINING RING 20MM
49	PR11M	EXT RETAINING RING 25MM
50	PB35M	HEX BOLT M12-1.75 X 40
51	P0717051	HYDRAULIC CYLINDER ASSEMBLY
52	P0717052	HYDRAULIC CYLINDER TOP PIN
52-1	P0717052-1	COTTER PIN #2 X 1"
53	P0717053	HYDRAULIC MOUNTING PLATE
53-1	PLW06M	LOCK WASHER 10MM
53-2	PB01M	HEX BOLT M10-1.5 X 30
54	PB33M	HEX BOLT M12-1.75 X 50
55	PW06M	FLAT WASHER 12MM
56	P0717056	LOCK PLATE
57	PN06	HEX NUT 1/2-13

REF	PART #	DESCRIPTION
58	P0717058	SPRING BRACKET
58-1	PB26M	HEX BOLT M8-1.25 X 30
58-2	PW01M	FLAT WASHER 8MM
58-3	PLW04M	LOCK WASHER 8MM
58-4	PN03M	HEX NUT M8-1.25
59	P0717059	SPRING EYE BOLT 1/2-12 X 8
60	P0717060	EXTENSION SPRING
61	P0717061	ANGLE SCALE
61-1	PRIV013M	STEEL FLUTED RIVET 2.5 X 4MM
62	PB35M	HEX BOLT M12-1.75 X 40
63	P0717063	DOCK WASHER 12MM
63-1	PLW05M	LOCK WASHER 12MM
64	P0717064	WISE JAW-OUTER
65	PB33M	HEX BOLT M12-1.75 X 50
66	P0717066	PIVOT WASHER 12MM
66-1	PLW05M	LOCK WASHER 12MM
67	P0717067	WISE JAW-INNER
68	PB35M	HEX BOLT M12-1.75 X 40
69	PCAP07M	CAP SCREW M6-1 X 30
69-1	PLW03M	LOCK WASHER 6MM
69-2	PW03M	FLAT WASHER 6MM
70	P0717070	ELECTRICAL PANEL COVER
70-1	P0717070-1	DOOR HINGE PIN
71	P0717071	FUSE BLOCK
72	P0717072	CONTACTOR NHD C12D 110V
72-1	P0717072	CONTACTOR NHD C12D 110V
73	P0717073	TRANSFORMER GDM 100VA
74	P0717074	TERMINAL BAR 15P



Saw Bow Breakdown



Saw Bow Parts List

REF	PART #	DESCRIPTION
7	P0717007	HOSE 5/16" X 51"
7-1	P0717007-1	HOSE CLAMP 14MM
40	P0717040	MOTOR TILT PLATE
75	P0717075	HANDLE
76	PTH001M	TRUSS HD SCR M6-1 X 16
77	PB02M	HEX BOLT M6-1 X 12
77-1	PLW03M	LOCK WASHER 6MM
77-2	PW03M	FLAT WASHER 6MM
78	P0717078	WIRE BRUSH GUARD
79	P0717079	UPPER BLADE WHEEL COVER
80	P0717080	LOWER BLADE WHEEL COVER
82	P0717082	DRIVE WHEEL SPACER
83	P0717083	DRIVE WHEEL WASHER
84	P0717084	DRIVE WHEEL
85	P0717085	BLADE 119-1/2L X 1-1/16W VP TPI
86	PB49M	HEX BOLT M12-1.75 X 20
87	PCAP50M	CAP SCREW M5-.8 X 10
88	P0717088	FILTER SCREEN
89	PB75M	HEX BOLT M12-1.75 X 35
89-1	PLW05M	LOCK WASHER 12MM
90	P0717090	LOCK KNOB 1/4-20 X 10
91	P0717091	SAW BOW SUPPORT
91-1	PLW06M	LOCK WASHER 10MM
91-2	PCAP72M	CAP SCREW M10-1.5 X 30
92	P0717092	SAW BOW
92-1	PSS13M	SET SCREW M10-1.5 X 12
94	P0717094	GEAR BOX ASSEMBLY
94-1	PK62M	KEY 7 X 7 X 45
95	PK66M	KEY 7 X 7 X 55
96	P0717096	PULLEY COVER
96-1	P0717096-1	LOCK KNOB 1/4-20 X 1/2
97	P0717097	GEAR BOX PULLEY
98	PVA39	V-BELT A39
99	P0717099	MOTOR PULLEY
99-1	PSS16M	SET SCREW M8-1.25 X 10
100	PB03M	HEX BOLT M8-1.25 X 16
100-1	PW01M	FLAT WASHER 8MM
100-2	PLW04M	LOCK WASHER 8MM
102	P0717102	SUPPORT SHAFT
102-1	PR08M	EXT RETAINING RING 19MM
103	PB75M	HEX BOLT M12-1.75 X 35
104	P0717104	MOTOR MOUNT BRACKET
104-1	PW06M	FLAT WASHER 12MM
104-2	PN06	HEX NUT 1/2-13

REF	PART #	DESCRIPTION
107	PB07M	HEX BOLT M8-1.25 X 25
108	PW01M	FLAT WASHER 8MM
108-1	PLW04M	LOCK WASHER 8MM
109	PB118M	HEX BOLT M8-1.25 X 45
109-1	PW01M	FLAT WASHER 8MM
110	P0717110	MOTOR MOUNT PLATE
111	P0717111	MOTOR 1-1/2 HP 110/220V 50/60HZ 1PH
111-1	PCS001	CENT SWITCH 5/8-1725
111-2	PCP003	CONTACT PLATE 1" X 2.5" EXT
111-3	PC400S	S CAPACITOR 400M 125V 1-3/4 X 3-3/8
111-4	PC040F	R CAPACITOR 40M 250V 1-3/8 X 2-3/8
111-5	P0717111-5	JUNCTION BOX
111-6	P0717111-6	CAPACITOR COVER
111-7	P0717111-7	FAN
111-8	P0717111-8	FAN COVER
111-9	P6203ZZ	BALL BEARING 6203ZZ
111-10	P6205ZZ	BALL BEARING 6205ZZ
112	PW01M	FLAT WASHER 8MM
112-1	PLW04M	LOCK WASHER 8MM
113	PN03M	HEX NUT M8-1.25
114	PK110M	KEY 7 X 7 X 12
116	PCAP14M	CAP SCREW M8-1.25 X 20
118	P608ZZ	BALL BEARING 608ZZ
118-1	PLW04M	LOCK WASHER 8MM
119	PB49M	HEX BOLT M12-1.75 X 20
120	PW06M	FLAT WASHER 12MM
121	P6205Z	BALL BEARING 6205Z
122	P0717122	IDLER WHEEL
123	P0717123	BLADE GUARD
123-1	PB03M	HEX BOLT M8-1.25 X 16
123-2	PW01M	FLAT WASHER 8MM
123-3	PLW04M	LOCK WASHER 8MM
124	P0717124	LEFT GUIDE BRACKET
124-1	PSS06M	SET SCREW M8-1.25 X 16
124-2	P0717124-2	NOZZLE
124-3	P0717124-3	NOZZLE SUPPORT
124-4	PLW03M	LOCK WASHER 6MM
124-5	PB02M	HEX BOLT M6-1 X 12
125	P0717125	SPACER 8 X 25MM
126	P6201ZZ	BALL BEARING 6201ZZ
127	P0717127	ECCENTRIC SLEEVE
127-1	P0717127-1	SLEEVE
128	PLW04M	LOCK WASHER 8MM
129	PCAP45M	CAP SCREW M8-1.25 X 45



Saw Bow Parts List (continued)

REF	PART #	DESCRIPTION
130	PCAP07M	CAP SCREW M6-1 X 30
130-1	PLW03M	LOCK WASHER 6MM
130-2	PW03M	FLAT WASHER 6MM
131	P0717131	TUNGSTEN CARBIDE BLADE GUIDE
132	PB126M	HEX BOLT M8-1.25 X 40
133	PLW04M	LOCK WASHER 8MM
133-1	PW01M	FLAT WASHER 8MM
134	P0717134	ADJUSTABLE BRACKET
135	P0717135	SCALE
135-1	PRIV013M	STEEL FLUTED RIVET 2.5 X 4MM
136	PCAP64M	CAP SCREW M10-1.5 X 25
137	P0717137	SLIDE
138	P0717138	LEFT BLADE BRACKET
140	PB31M	HEX BOLT M10-1.5 X 40
140-1	PW04M	FLAT WASHER 10MM
141	P0717141	BLOCK
142	P0717142	LOCK KNOB 3/8-16 X 2
143	PSS16M	SET SCREW M8-1.25 X 10
144	P0717144	RIGHT BLADE BRACKET
145	PB02M	HEX BOLT M6-1 X 12
145-1	PLW03M	LOCK WASHER 6MM
146	PW03M	FLAT WASHER 6MM
147	P0717147	WIRE BRUSH
148	P0717148	BUSHING
149	P0717149	RIGHT GUIDE BRACKET
150	P0717150	BRUSH BRACKET
151	PB02M	HEX BOLT M6-1 X 12
152	PLW03M	LOCK WASHER 6MM
153	PW03M	FLAT WASHER 6MM
155	PN09M	HEX NUT M12-1.75
155-1	PB27M	HEX BOLT M12-1.75 X 30
155-2	PLW05M	LOCK WASHER 12MM
155-3	PW06M	FLAT WASHER 12MM
156	P0717156	SAW BOW STOP M12-1.75 X 50
157	P0717157	BLADE GUARD
158	P0717158	KNOB 1/4-20 X 3/8"
159	P0717159	HOSE 8 X 700MM
160	P0717160	ADJUSTING VALVE
160-1	P0717160-1	HOSE 8 X 320MM
160-2	P0717160-2	HOSE CLAMP 14MM
160-3	P0717160-3	VALVE BRACKET
160-4	PLW03M	LOCK WASHER 6MM

REF	PART #	DESCRIPTION
160-5	PB02M	HEX BOLT M6-1 X 12
161	P0717161	POWER INDICATOR LIGHT TEND
162	P0717162	START SWITCH TEND
163	P0717163	EMER STOP SWITCH KEDU HY57B
164	P0717164	PUMP SWITCH TEND
165	P0717165	SPEED CONTROL VALVE
166	P0717166	CONNECTION TUBE
166-1	P0717166-1	HOSE 5/16 X 15-3/4"
166-2	P0717166-2	HOSE 5/16 X 37"
168	P0717168	CONTROL BOX
169	P0717169	CONTROL PANEL
169-1	P0717169-1	HYRAULIC MICRO-ADJUST VALVE
169-2	P0717169-2	ON/OFF SWITCH
170	PS05M	PHLP HD SCR M5-.8 X 8
172	P0717172	HANDLE M12-1.75 X 30
173	PN09M	HEX NUT M12-1.75
174	PSS08M	SET SCREW M4-.7 X 5
174-1	P0717174-1	HINGE PIN
175	PS09M	PHLP HD SCR M5-.8 X 10
176	P0717176	INDICATOR SCALE
177	P0717177	SLIDE BRACKET
178	P0717178	TENSION SHAFT
179	PK20M	KEY 5 X 5 X 15
180	P0717180	HANDWHEEL
181	P0717181	CONICAL SPRING 22 X 45 X 6MM
182	P0717182	SPACER 22MM
183	P0717183	TENSION INDICATOR
184	P51104	THRUST BEARING 51104
187	P0717187	BLADE WHEEL GUIDE
188	PSS02	SET SCREW 5/16-18 X 3/8
189	P0717189	EXTENSION CYLINDER
190	P0717190	BLADE WHEEL SHAFT
191	PN13M	HEX NUT M16-2
191-1	PSS03M	SET SCREW M6-1 X 8
192	PCAP14M	CAP SCREW M8-1.25 X 20
193	PCAP129M	CAP SCREW M12-1.75 X 20
193-1	P0717193-1	AXLE WASHER
194	P0717194	GIB
195	P0717195	WHEEL ALIGNMENT BOLT M16-2 X 30
196	PB34M	HEX BOLT M10-1.5 X 60
197	PLW06M	LOCK WASHER 10MM





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